

# NATIONAL CAR-BUILDER

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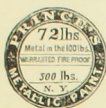


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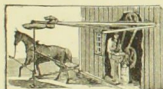
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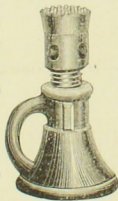
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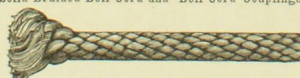
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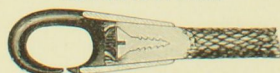
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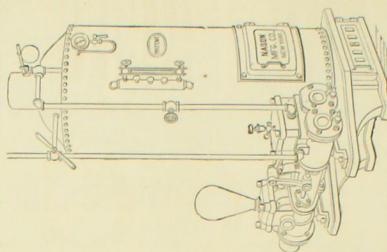
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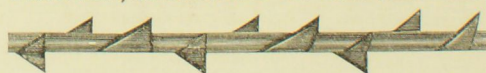
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[OCTOBER, 1881.]

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i

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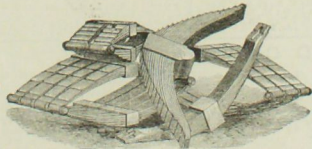
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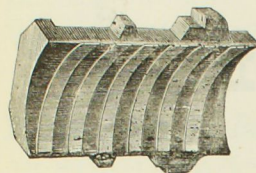
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## PATENT LEAD-LINED SELF-FITTING JOURNAL BEARINGS,

AND

Meneely's Patent Bell-Metal Ended Journal Bearings, for reducing Lateral Wear.

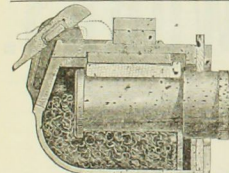
MADE BY

**GEORGE R. MENEELY & CO.,** West Troy, N. Y.

ESTABLISHED 1847.

## A. WHITNEY & SONS' CAR WHEEL WORKS,

PHILADELPHIA.



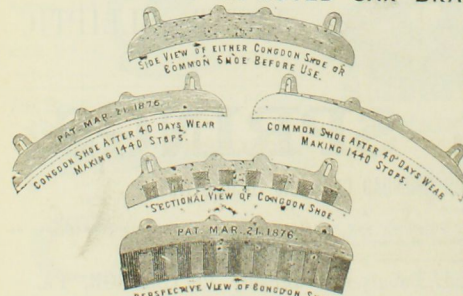
## THE HEWITT BOX-LID CO.,

142 DEARBORN STREET,

CHICAGO ILL.

We respectfully refer you to the following railroads using the Hewitt Cover.  
K. C. N. J. & C. R. M. H. P. S. & O. C. B. & Q. C. A. & S. L. A. T. & S. F. A. & N. E. P. & P. M. D. L. & N. D. & R. C. M. C. H. & S. L. C. & V. S. L. L. N. & S. H. & M. R. (in Neb.) D. P. L. & O. D. H. & S. L. C. & V. S. L. L. I. C. O. C. S. L. V. & T. H. S. P. & S. C. S. P. C. & R. I. M. P.

## CONGDON'S IMPROVED CAR BRAKE SHOE.



PERSPECTIVE VIEW OF CONGDON SHOE.

G. M. SARGENT, General Manager, Grand Pacific Hotel, Chicago, Ill.

This improvement consists of a shoe, having imbedded in its body of cast iron, pieces of wrought iron, steel, malleable iron, or other suitable metal, fixed therein so as to appear in sections on the wearing surface of the shoe, which increases surprisingly its resistance to wear, and adds materially to the friction or adhesion of the shoe to the surface of the wheel. These shoes are now in extensive and general use on many prominent railroads, and are effecting a saving of over fifty per cent. Communications should be addressed to either of the following parties: THE CONGDON BRAKE SHOE CO., GRAND PACIFIC HOTEL, CHICAGO, RAMAPO WHEEL & FOUNDRY CO., RAMAPO, N. Y.; J. H. BASS, CHICAGO; BASS FOUNDRY & MACHINE WORKS, FORT WAYNE, IND.; ST. LOUIS CAR WHEEL CO., ST. LOUIS, MO.

THE CONGDON BRAKE SHOE CO.

## THE PERRY SAFETY FREIGHT COUPLING.

About 2,000 of them are at work on the E. & T. H.; C. & E. I.; C. R. I. & P.; T. H. & I. railroads since Dec. 1. The two first named roads have adopted it wholly for their freight cars. This coupling carries its own "stick" and with it the "bones" can couple cars with their "kicks" on. Full size working models at W. V. PERRY'S (General Agent), 224 South Clark Street, Chicago, Ill.

## CRANE BROTHERS MFG. CO.

Offices, No. 10 N. Jefferson St., Chicago.

MANUFACTURERS OF

## WROUGHT IRON PIPE,

Brass and Iron Goods

For Steam and Gas Fitters and Engine Builders,

CAST IRON and MALLEABLE IRON FITTINGS

Steam Pumps, Injectors, &amp;c.,

Hollow Stay-Bolt Iron, Babbitt Metal, &amp;c.

MALLEABLE IRON CASTINGS,

GRATE BARS, &amp;c., &amp;c.

JOYCE, CRIDLAND &amp; CO.,

Cor. Wyandotte St. and Railroad.

DAXTON, O.

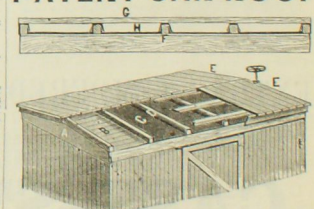
MANUFACTURERS OF

## LEVER, COMPOUND LEVER, AND

Screw Jacks.

We make 27 varieties of these Jacks, and have more in process of construction. Send for Illustrated Catalogue and Price List.

## WINSLOW'S PATENT CAR ROOF



A Carline or Main Rafter. B Sub or under-rafter. C Asph. Felt, and when on Car painted with imperishable Asphalt paint. D Felt Cap or Sub Rafter. E Upper board roof. F Sub Rafter. G Stringers on sub rafters. H Air Space between the Felt and upper board roof. This roof must come into general use by Railway Companies and Manufacturers of Truck and Freight Cars for two reasons, CHEAPNESS and DURABILITY, as it can be furnished on the cars at the cost of a first-class double board roof, and is more durable than the best metallic roof, being thoroughly protected by the upper and lower boarding, and the FELT, which is treated in its manufacture with ASPHALT and painted with the same imperishable material, which, not being affected by either heat or cold, must last the ordinary life of a car.

MANUFACTURED BY  
**A. P. WINSLOW & CO.,**  
CLEVELAND, OHIO.



[OCTOBER, 1881.]

R CO.,

ANY,

Freight Coupling.

ERS MFG. CO.

fferson St., Chicago.

IRON PIPE,

Iron Goods

ABLE IRON FITTINGS

Injectors, &c.

Babbitt Metal, &c.

ON CASTINGS,

RS, &c., &c.

LAND & CO.,

Dayton, O.

MANUFACTURERS OF

EVER.

POUND LEVER,

AND

crew Jacks.

LOW'S

AR ROOF

OCTOBER, 1881.]

THE NATIONAL CAR-BUILDER.

iii

## LOWE'S METALLIC PAINT COMPANY, CHATTANOOGA, TENNESSEE,

MANUFACTURERS OF

# LOWE'S METALLIC PAINT!

This Paint has now been before the public sufficiently long to establish its qualities as first-class Metallic Paint in every respect. It has covering properties superior to any other Metallic Paint made.

It takes about 18 per cent. less Oil than any other Metallic Paint.

It is absolutely free from Sulphates of every kind and description, which in many other Metallic Paints prove so injurious to Iron and Tin Roofs. It is manufactured in a very superior manner by being re-ground and carefully prepared, and is entirely available for inside finish when dark colors are desired. Its natural color is a Uniform Dark Blood Red. It is

Warranted not less than 55 per cent Metallic Iron,

thus giving it a body excellent by no other Paint made. Its Fire Proof properties are excellent, and houses constructed of wood, and especially shingle roofs, are very materially protected by application of this Paint. It is not calculated for burnt, consequently its color is unchangeable. We have Freight arrangements to nearly every city in the United States and Canada, and would name Prices delivered. Please read the Certificates hereto attached.

East Tennessee, Virginia & Georgia Railroad—Main Stem, Knoxville, Tenn., April 18, 1881.

S. B. Lowe, Chattanooga, Tenn.: Dear Sir: \* \* \* I will say that this company is using it both upon its Main Stem and Selma Division, and has found it perfectly satisfactory, and equal to any Lehigh Brown that we have used. It mixes well and spreads smoothly, and I find it much the cheapest paint that I can use for freight cars and such purposes. Very truly yours, JNO. F. O'BRIEN, Gen'l Supt.

Wilkins, Post & Co., Engineers and Bridge Builders, Atlanta, Ga., and 102 Broadway, N. Y., Atlanta, May 16, 1881.

S. B. Lowe, Chattanooga: Dear Sir: We have been using your paint on all the iron bridges that we are constructing on the M. & C. Georgia Western, and other railroads through the South, and find it of very superior quality requiring less oil and working with ease, and having excellent covering properties. Respectfully, WILKINS, POST & CO.

Office of Peaselee, Gaulbert & Co., Manufacturers of White Lead, Colors, Ready Mixed Paints, etc., Louisville, Ky., April 15, 1881.

Lowe's Metallic Paint Co., Chattanooga, Tenn.: Dear Sir: \* \* \* Your Metallic Paint has given perfect satisfaction wherever we have placed it. In grinding we find it takes from ten to twenty-five per cent. less oil than various other brands of oxide of iron we have heretofore handled. Very truly yours, PEASLEE, GAULBERT & CO.

King's Iron Bridge & Manufacturing Co., Cleveland, O., May 22, 1881. Lowe's Metallic Paint Co., Chattanooga, Tenn.: Gentlemen: We find your paint of first-rate quality for our use, and very economical. Yours truly, KING BRIDGE CO.

Office of Scott & Co., Manufacturers of Scott's Sheet Iron Roofing, Cincinnati, May 4, 1881.

Lowe's Metallic Paint Co., Chattanooga, Tenn.: Gentlemen: We consider it as good as any that we have used during our experience of over nine years, and shall use it largely. Yours, etc., SCOTT & CO.

W. G. Hyndman & Co., Manufacturers of Patent Sheet Iron Roofing, Cincinnati, May 3, 1881.

Lowe's Metallic Paint Co., Chattanooga, Tenn.: Gentlemen: The paint which we received from you last month has given us perfect satisfaction. We regard it as the best iron ore paint that we have ever used. Respe. fully yours, W. G. HYNDMAN & CO.

P. S.—Please forward us immediately two (2) tons more on our order. Wason Car and Foundry Co., Chattanooga, Tenn., May 3, 1881.

S. B. Lowe, City: Dear Sir: For some time past we have been using the Lowe's Metallic Paint upon all the cars built at our shops, and, as it gives entire satisfaction to our customers, it is our purpose to continue the use of it. F. F. MORRILL, Sec'y.

Cincinnati, Hamilton & Dayton R. R. Co., Operating the Dayton & Michigan, C. & O., Richmond & Chicago, and C. H. & I. R. R's.

W. H. H. Allison, Master Car-Builders, Cincinnati, June 14, 1881.

Lowe's Metallic Paint Co., Chattanooga, Tenn.: Gentlemen: We have been using your Metallic Paint on freight cars, at our shops, for the last four months, and find it a better paint than we ever used for that purpose. Yours respectfully, W. H. H. ALLISON.

Laboratory of Fred P. Dewey, Chemist to Evans Iron Co., Chattanooga, Tenn., April 6, 1881.

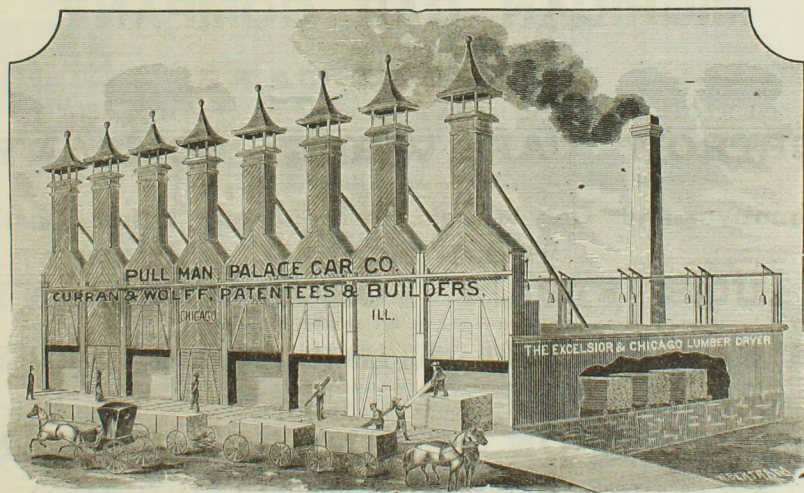
S. B. Lowe, Esq.: Dear Sir: I have given samples of your paint ore a careful analysis with a special view of ascertaining if there is any substance in it calculated to prove injurious to tin or iron roofs, and am free to say that I find it remarkably free from sulphides of every kind, or anything else that could prove injurious to either tin or iron roofs. Yours respectfully, FRED P. DEWEY, Ph. R., Analytical Chemist.

Office of Norton & Wiedner, Paints, Oils, Varnishes, Glass, Sash, Doors and Blinds, St. Louis, May 30, 1881.

Lowe's Metallic Paint Co., Chattanooga, Tenn.: Gentlemen: We have used and sold—in the course of the past year—enormous quantities of your Metallic Paint, and we find that less oil is required for years than for other Metallic Paints. Yours truly, NORTON & WIEDNER.

## THE EXCELSIOR AND CHICAGO LUMBER DRYER IS BUILT UNDER 16 PATENTS.

PAYS FOR ITSELF EVERY YEAR.  
Storing Capacity, 40,000 feet Inch Lumber.



DRYING 40,000 FEET PINE LUMBER EVERY 24 HOURS.

RAILROAD COMPANIES AND CAR-BUILDERS WHO ARE USING THE EXCELSIOR AND CHICAGO LUMBER DRYER.

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Pullman Palace Car Company, Chicago..... 8	Memphis & Charleston Railroad, Me. phis..... 2
Wells & French Co., Chicago..... 3	Ohio Falls Car Company, Jeffersonville, Ind..... 2
C. & N. W. Railroad, Chicago..... 2	Indiana Car Company, Cambridge City, Ind..... 2
Flat & Perry Marquette R. R., Saginaw..... 1	Hankel & Barker Company, Michigan City, Ind..... 2
Pennsylvania Car Works, Detroit..... 1	Denver & Rio Grande Railway, Denver, Col..... 2
Michigan Car Company, Detroit..... 1	

CURRAN & WOLFF, Proprietors and Builders, 39 and 41 FRANKLIN STREET, CHICAGO, ILL.



**WASON CAR & FOUNDRY CO.,**

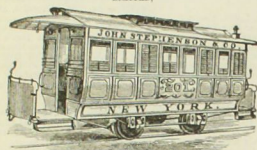
CHATTANOOGA, TENN.,

MANUFACTURERS OF

FREIGHT CARS,  
CAR WHEELS,  
AND  
CASTINGS OF ALL KINDS.

**GILL CAR**  
M'F'G CO.,  
Columbus, Ohio.  
Make the best CARS and WHEELS.

John Stephenson Co.,  
LIMITED,



**STREET CARS**  
AND OMNIBUSES,  
47 East Twenty-Seventh St., New York.

**ERIE CAR WORKS (LIMITED).**

ERIE, PA.

Capacity 16 Cars Per Day.

FREIGHT CARS OF BEST MATERIAL, AND CONSTRUCTION A SPECIALTY.

H. M. CLAPLEN, President.  
J. N. ASHBURN, Secretary.S. SHELTON, Engineer.  
W. REUSCHEL, Asst. Eng'r

CLEVELAND BRIDGE &amp; CAR WORKS,

BUILDERS OF

**BRIDGES AND ROOFS,**

EITHER OF IRON OR WOOD. ALSO

FREIGHT AND STREET RAILWAY CARS,

WITH ALL DESIRABLE IMPROVEMENTS.

Manufacture Car Wheels and Castings of All Kinds.

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LITCHFIELD CAR AND MACHINE COMPANY,  
LITCHFIELD, ILLINOIS.

Manufacturers of all kinds of Passenger and Freight Equipment, both Wide and Narrow Gauge.

CAR WHEELS A SPECIALTY IN THE MACHINERY DEPARTMENT.

Especially attention is given to furnishing Hoisting Engines, Pit Cars, Dumps, etc., etc., for Coal Mines, as well as building Stationary Engines and Boilers, and General Brass and Sheet-Iron Work.

**PARDEE CAR WORKS.**

WATSONTOWN, PA.,



PARDEE, SNYDER &amp; CO., Limited, Proprietors.

MANUFACTURE



Mail, Baggage, Box, Gondola, Flat, Gravel, Ore, Coal, Mine and Hand Cars,  
Kelley's Patent Turn-Tables and Centres for Wooden Turn-Tables,  
Car Castings, Railroad Forgings, Rolling-Mill Castings,  
Bridge Bolts and Castings.

We have in connection with our Car Works an extensive Foundry and Machine Shop, and are prepared to do a general  
Machine Business.  
ARIO PARDEE, Chairman. H. F. SNYDER, Treasurer and General Manager. O. LEISER, Secretary.

**MICHIGAN CAR COMPANY,**

Manufacturers of

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HUGH McMILLAN, V. Pres. and Gen. Manager.

JAMES MCCORROR, General Superintendent.

**RAILROAD CARS,**

H. W. DYAR, Assistant Manager.

W. K. ANDERSON, Treasurer.

JOSEPH TAYLOR, Secretary.

OFFICE: NO. 2 MOFFAT BLOCK, DETROIT, MICH.

**DETROIT CAR WHEEL COMPANY,**

Manufacturers of

Locomotive and Car Wheels, Railroad and Other Castings,

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DETROIT, MICH.

J. H. WHITING, Superintendent.

W. K. ANDERSON, Secretary and Treasurer.

**BAUGH STEAM FORGE COMPANY,**

Manufacturers of all Descriptions of

CAR AND DRIVING AXLES, COUPLING LINKS AND PINS, SHAFTINGS, DRAW BARS, ETC.

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Works on River Road, Below City,  
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W. K. ANDERSON, Secretary.**DETROIT IRON FURNACE COMPANY.**

LAKE SUPERIOR CHARCOAL PIG IRON,

FOR CAR-WHEEL AND MALLEABLE USE.

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DETROIT, MICH.

LEE BURT, Manager.

E. C. WETMORE, Secretary



[OCTOBER, 1881.]

THE NATIONAL CAR-BUILDER.

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## MIDDLETOWN CAR WORKS

MICHAEL SCHALL & ARTHUR KING, Proprietors,

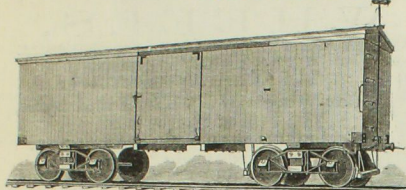
## RAILWAY AND MINE CARS.

SPECIAL ATTENTION GIVEN TO CAR REPAIRS.  
MIDDLETOWN, PA.

## LEHIGH CAR, WHEEL & AXLE WORKS,

McKEE & FULLER,

CATASAUQUA, PA.,



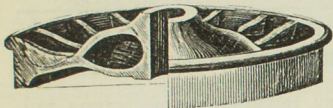
MANUFACTURERS OF  
Broad and Narrow-Gauge  
FREIGHT AND COAL CARS  
OF EVERY DESCRIPTION.

WHEELS  
For Freight, Locomotive,  
Truck, Tender, and  
Passenger Service.

Hammered Axles,  
AND OTHER FORGINGS.

CAPACITY:

16 Box-Cars Per Day.  
250 Wheels Per Day.  
Wheels Fitted to Axles, and Prices  
Furnished on Application.



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CAR WHEELS AND RAILWAY CASTINGS.

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WILMINGTON, DEL.

ESTABLISHED IN 1836.

MANUFACTURERS OF EVERY DESCRIPTION OF

# RAILROAD CARS.

## VANDERBILT & HOPKINS,

RAILROAD TIES, CAR AND RAILROAD  
LUMBER, WHITE AND YELLOW  
PINE AND OAK,

No. 120 Liberty St., New York.  
Also North Carolina Pine Boards, Plank and Dimension  
Lumber to Order.

GENERAL RAILROAD SUPPLIES.

## J. M. JONES & CO.,

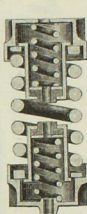
SCHENECTADY, NEW YORK.

(Established Over 40 Years.)



Our Cars have all Late and Valuable Improvements. Are  
noted for Light Running and Easy Riding. Combining  
Lightness and Strength with Beauty in Design and Finish.  
Our large Facilities enable us to fill orders quickly and at  
the lowest prices for superior quality.

Manufacturers of Street Railway Cars.



Cliff's Graduated

STREET-CAR

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MANUFACTURED BY

Cliff & Righter,

No. 5 Dey Street,

NEW YORK.



T. B. SMITH, Sec'y and Treas.



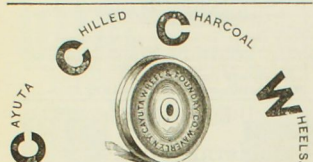
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ESSEX AND BURKE STS., BALTIMORE, MD.

MANUFACTURERS OF  
**Chilled Wheels of all Patterns and Sizes,**  
FOR EVERY SERVICE, AND WITH OR WITHOUT AXLES.  
W. S. G. BAKER, President. J. M. LAWFORD, Secretary and Treasurer.  
S. P. RABER, Sup't. L. H. TAYLOR, Pres. J. H. WALKER, Sec. and Treas.



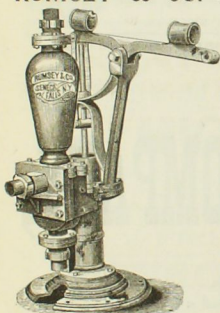
**TAYLOR IRON WORKS,**  
High Bridge, N. J.,

MANUFACTURERS OF  
Chilled Iron Car-Wheels, Steel-Tired Wheels, Car  
and Locomotive Axles and Draw Hooks.



MANUFACTURED BY  
**CAYUTA WHEEL AND FOUNDRY COMPANY,**  
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M. LYMAN, JR.,  
Superintendent and Treasurer.

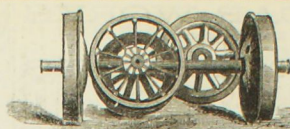
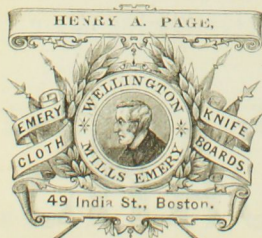
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Manufacturers of  
OVER 800 DIFF-  
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OF PUMPS.  
More than 50  
Railway Com-  
panies have them  
in use.  
ALSO  
FIRE ENGINES,  
ETC., ETC.  
ASK FOR  
RUMSEY'S  
PUMPS  
and address for  
Catalogue and  
full information.  
RUMSEY & CO.,  
SENECA FALLS,  
New York.

**HOWARD IRON WORKS,**

BUFFALO, N. Y.  
MANUFACTURERS OF  
Schlenker's Automatic Revolving Die Bolt Cutter  
And Nut Tapping Machine,  
SPECIALLY ADAPTED FOR R. R. WORK.



**MOWRY**  
**CAR WHEEL WORKS,**  
CINCINNATI, O.

Manufacturers of CAR WHEELS of all descriptions,  
Wheels and Axles, Chilled Tires, Engine, Car and  
Bridge Castings, of any pattern, furnished to order at  
short notice. Wheels of all sizes constantly on hand.  
OFFICE: No. 27 1/2 W. Third St., Cincinnati, O.  
WORKS: Eastern Avenue and Lewis Street.  
L. A. GREEN, Sup't, Cincinnati, O.

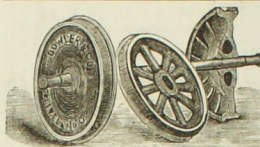
**DAVENPORT, FAIRBAIN & CO.,**

ERIE, PA.

MANUFACTURERS OF

**CAR WHEELS,**

Capacity 500 Wheels per day. Wheels made by improved process. Far more durable than those made in the ordinary way.



**CLEVELAND FOUNDRY,**

Car Wheels of all Kinds and Sizes,  
WITH OR WITHOUT AXLES.  
**CHILLED-FACED RAILROAD FROGS.**  
Street Railroad Turnouts.  
ROLLING MILL AND MACHINERY CASTINGS.  
Nos. 9, 11 and 13 Winter Street, Cleveland, Ohio.  
BOWLER & CO.

**Cleveland Wheel and Foundry Works,**

MAHER & BRAYTON, Proprietors.

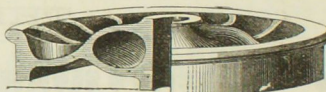
MANUFACTURERS OF

CAR, ENGINE, TRUCK AND TENDER WHEELS, RAIL-  
ROAD, ROLLING-MILL AND MACHINERY CASTINGS,  
AND STREET RAILROAD WHEELS AND TURNOUTS.

ALSO,

**CHILLED-FACED RAILROAD FROGS.**

Office: 20 Carter St. Works: Corner Carter and Collins Sts.  
CLEVELAND, O.

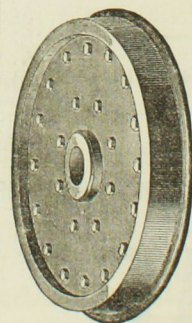


**RAMAPO WHEEL AND FOUNDRY CO.**

MANUFACTURERS OF

**CHILLED WHEELS FOR DRAWING-ROOM AND SLEEPING COACHES**  
**LOCOMOTIVES, TENDERS, PASSENGER AND FREIGHT CARS.**  
GEO. CHURCH, Pres't and Treasurer. W. W. SNOW, Sup't and Gen'l Manager.  
RAMAPO, ROCKLAND COUNTY, N. Y.

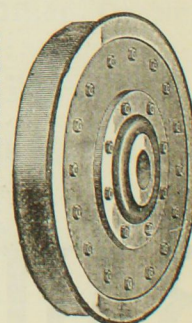
**ALLEN PAPER CAR WHEEL CO.,**



GENERAL OFFICES:  
240 BROADWAY, NEW YORK.



MANUFACTURERS OF ALLEN'S PATENT  
**PAPER CAR WHEEL.**  
ALL SIZES.



Especially adapted for Sleeping and Drawing Room Cars, Locomotive and Tender Trucks. Steel Tire with Annular Web—Strongest, Most Durable, and Most Economical Wheel in use. Works at Hudson, N. Y., and at Pullman (near Chicago, Ill.).  
A. G. DARWIN, President. J. C. TRACON, Treasurer. C. R. ASTEN, Secretary.



OCTOBER, 1881

WRY  
EL WORKS,  
NATI. O.  
FHEELS of all descriptions  
of Tires, Engines, Cars and  
other machinery, to order at  
very low prices. Also, to  
order at low prices.  
100 and Lewis Street  
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made in the ordinary way  
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nds and Sizes,  
AXLES  
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Turnouts.  
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et, Cleveland, Ohio.  
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Proprietors.

R WHEELS RAIL-  
RY CASTINGS.  
AND TURNOUTS.  
AD FROGS.  
arter and Collins Sts.

DRY CO.  
VOACHES  
IGHT CARS.  
d Con'l Manager.  
Y, N. Y.  
EL CO.,



th Annual Wheel-Grinding  
Machine Co.  
G. A. HUNTER, Secretary.

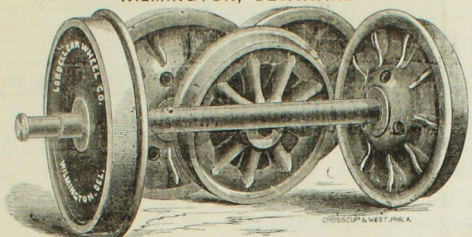
OCTOBER, 1881.]

THE NATIONAL CAR-BUILDER.

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# LOBDELL CAR WHEEL CO., W.D. WOOD & CO'S

WILMINGTON, DELAWARE.



## PATENT PLANISHED SHEET IRON

Patented March 14, 1875; April 8, 1873;  
Sept. 2, 1871; Oct. 6, 1874; Jan. 11, 1876.  
Guaranteed fully equal, in all respects, to the  
IMPORTED RUSSIA IRON,  
And at a much less price.  
Locomotive Jacket Iron

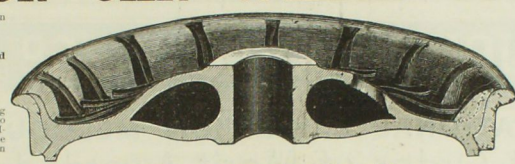
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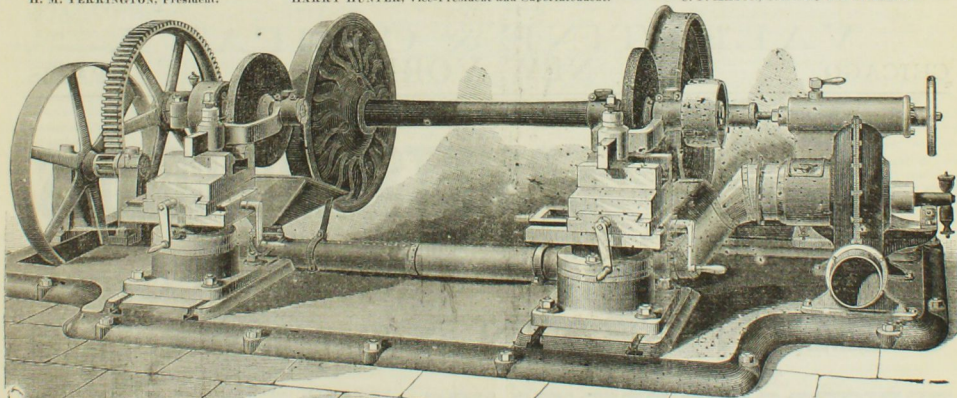
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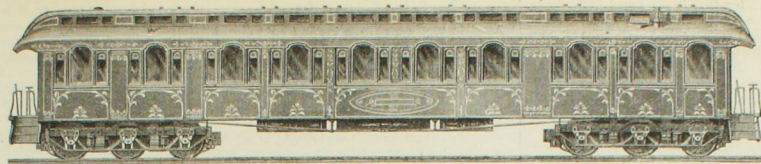
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VOLUME XII:  
NUMBER 10

OCTOBER, 1881.

SINGLE NUMBERS, TEN CENTS,  
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## Miscellaneous Items.

THE Wabash, St. Louis & Pacific road is building new car shops at Decatur, Ill.

THE Baltimore & Ohio fast passenger locomotives running between Baltimore and Washington, have 19x24 cylinders and 6-foot drivers. The valves have 6-inch travel,  $\frac{3}{4}$  in. outside, and no inside lap.

THE new and uncompleted works of S. B. Shaw & Co., of St. Louis, designed originally for the manufacture of iron and steel rails, are to be changed into car works.

SEVERAL new postal cars are to be built at the Lake Shore shops at Adrian, Mich. They are intended for the New York & Chicago line, and will be models in construction and equipment.

THE Atchison, Topeka & Santa Fe road has a 17 x 28 cylinder passenger engine, which is very efficient on steep grades, and will start a heavier train on them than any other engine. The road is building several more of them.

THE Milwaukee, Lake Shore & Western road is receiving from the Barney & Smith Co. 250 box, and also some caboose cars, 34 and 38 ft. long respectively. The road has adopted a light drab as the standard color for all its cars.

THE Chicago, Burlington & Quincy road has two consolidation locomotives in service on the division between Aurora and Galesburg. It is getting ten more from the Baldwin works, and ten standard 8-wheel engines from the Manchester works.

THE Illinois Central shops at Chicago have just completed 25 Tiffany refrigerator cars. Some suburban cars have also been built at these shops and are proving very acceptable to the public. They are 45 ft. long in the body, seat 54 passengers, and weigh only 15 tons.

THE Capital City Car Works, of Columbus, Ohio, are about completed, and will have a capacity of ten freight cars a day. The arrangement and fitting up are such as to secure the utmost convenience and saving of time and labor. They have orders in hand for 1,300 cars to begin on.

THE standard passenger car upon western roads is 15 feet high and 10 feet 3 inches wide. The widest car that can get through some of the bridges and tunnels between New England and the West is 10 feet. It is claimed that the extra 3 inches gives more commodious seats and berths.

THE New York Central is putting driving wheel brakes on its passenger engines, the brakes being an improved attachment to the Westinghouse air-brake. Both train and engine brakes are thrown on and off by the same lever, although the attached driver-brake can be operated when an engine is disconnected.

THE Litchfield (Ill.) Car Co. has work in hand for several months ahead, upon orders for the various classes of freight cars for Western and South-western roads. It has just completed six combi-

nation baggage, mail and passenger cars for the Eastern Texas—length of bodies 48 feet, and seating 34 passengers.

MR. W. S. ROGERS, of Columbus, O., has patented an invention for lighting the platforms of passenger cars. It consists of a curved mirror or reflector placed at an angle under the hood, so as to receive the light from a lamp reflector inside the car through a glass panel, and throw it on the platform. Such a convenience can hardly fail to be appreciated.

THE Aurora (Ill.) shops of the C., B. & Q. road are building 8 palace parlor cars which will be unsurpassed in elegance and convenience. They will have reclining chairs, and among other novelties, a baggage and coat room in hotel style. The cost is estimated at \$10,000 each. They will run between Chicago and Kansas City and Des Moines and Omaha.

A NEAT little volume of 64 pages on "The Treatment of Steel," has been issued by Miller, Metcalf & Parkin, of Pittsburgh, embodying a series of circulars on heating, annealing, forging and tempering. It is handsomely illustrated, and the information it contains will be appreciated by the manufacturers and users of the product in its diversities of quality, treatment and management.

A SYSTEM of lighting railroad cars with gas has been tried on the Baltic Railway. The gas is made on the cars by the action of sulphuric acid and zinc, the resulting hydrogen being carburized by being passed through naphtha vapor. It is said that the gas has very little odor, that its flame is bright, white and constant, and that it is cheaper and gives better results than stearine candles.

THE discomfort of traveling in India in hot weather is decreased on the line of the great Indian Peninsular company by an ingenious device. The windows in every first-class railway carriage are provided with screens made of fragrant khas khas grass, which are kept constantly damp by mechanism connected with the wheels. By this means the air is kept sweet and comparatively cool.

AT the Kansas City shops of the K. C., F. S. & G. road, about 150 cars are built a year, including way and mail cars. The road is adopting the M. C. B. standard axle and journal bearing, and substituting curtains for blinds in passenger cars. It also has continuous draw-bars on 800 freight cars, and is putting them on all new cars. Six reclining-chair cars will soon be added to its passenger equipment.

TIFFANY REFRIGERATOR CARS have delivered dressed beef in Boston in six days from Chicago, and in perfect condition. The outside temperature when shipped was 80, and from 42 to 44 inside the cars on arrival. But a small quantity of ice is used in the cars, and no salt, and they are thoroughly ventilated. The National Dispatch Line has now 300 Tiffany cars running between Chicago and Boston. This looks like a revolution in this branch of the provision business.

IT is now proposed that locomotive engineers shall do their own bell-ringing. They already do the whistling, and on passenger trains the braking; and some inventive demon is doubtless arranging a plan by which they can do their own "firing." And while they are doing all this they must look out for signals, train robbers, malicious obstructions and carry a silver watch that will run like a chronometer. In a word, engineers are expected to make themselves generally useful.

IN Brazil, within an area of half a square mile, Agassiz counted 117 different kinds of wood, many of them admirably fitted by their hardness, tints, and beautiful grains, for the finest cabinet work. The tortoise-shell wood, undoubtedly the most precious wood in the world, is found in large quantities on the upper Amazon, where the water can be most easily supplied as motive power. Other woods, which are rivals of the most beautiful walnut, are wasted yearly on the Amazon in amounts ample enough to veneer all the palaces of Europe.

THE Philadelphia street car lines are waiting the result of the wire-rope system now on trial in Chicago. If it will stand the coming winter there, it will be introduced in Philadelphia next summer. The anticipated advantages are greater speed, better accommodations, and less cost of maintenance. The pipe which contains the rope will be laid between the tracks, but will not interfere with the free public use of the street, as the grooved opening from the surface into the pipe, by which the car is attached to the rope, will be but three-quarters of an inch wide.

THE Jackson & Sharp Co., of Wilmington, Del., has just completed two palace excursion cars for the Worcester (Mass.) Excursion Co. They are 66 feet long in the body, run on six-wheel trucks, and are designed chiefly for hunting parties, who desire to make long trips. The ornamentation and general fitting up are very elaborate and tasteful. The interior is finished in oiled mahogany relieved with marquetry, and is replete with the usual hotel car conveniences, including Paige's patent removable berths. The company is also filling an order for 50 passenger cars for the Denver & Rio Grande road, and also for three special cars for the use of the officers of the road.

THE Ohio Falls Car Co. recently delivered to the Nashville, Chattanooga & St. Louis road two passenger cars. The outside is painted brown, and the inside finished in ash and cherry. The seats are larger than usual, and the windows as wide as the space occupied by the seat. Storm doors are provided, which keep out dust and cinders when the other doors are open. At one end of the car a washstand and mirror have been provided in a small apartment for that purpose. Every new improvement has been introduced, including a steam-heating apparatus, which does away with the necessity of stoves.

THE Petaluma, Cal., Argus says that in Sonoma County there is an original and successful piece of



railroad building that is not found in the books. Between the Clipper mills and Stuart's Point, where the road crosses a deep ravine, the trees are saved off on a level and the timber and ties laid on the stumps. In the center of the ravine two huge redwood trees, standing side by side, form a substantial support, and they are cut off 75 ft. above the ground and cars loaded with heavy saw logs pass over them with as much security as if it were framed in the most scientific manner. There are many places in our redwood forests where this example might be followed profitably, as it would be cheaper to grade through with a cross-cut saw, and lay the ties on the stumps than to remove the trees.

At Escanaba, Mich., the Chicago & Northwestern road has its ore docks, for loading iron ore into vessels by gravity. They are built on trestles much like coal chutes. The last one built contains over 4,000,000 feet of lumber. The three docks have a water front of one and a half miles. They contain 558 pockets, which will hold 54,000 tons of ore. In the month of August there were shipped through them 270,000 tons of ore, which is equal for freight to 10,800,000 bushels of corn. These docks give employment to 175 men day and night. The night gang works by the light of 18 Brush electric lamps. From 90 to 100 loads of ore arrive daily. The road owns nearly 4,000 dump or ore cars, which are kept in repair by the road's shops at this place. They repair about 500 a month, and rebuild 25. So far this season they have built 196 new ones. The road is having 300 built by the Michigan Car Works, at Detroit. In 1867, the road built here a brick round house of 15 stalls. Last year 17 more were added, which makes the present round house two stalls more than a half circle. This season it is building a brick machine shop 80 x 292 ft. and a blacksmith and boiler shop 50 x 292 ft. x 30 ft. of the machine shop is two stories with offices up stairs and a store room and a tool room on the ground floor. Next season they will add a car shop 80 x 400 ft. The present shops employ 150 men.

Two new first-class carriages have been built as a trial by the London & Northwestern Railway Company. They are coupled together by a covered passage, and the great feature of the new arrangement is a gangway running from end to end, into which various small compartments open. At each of the two extreme ends of the coupled carriages a compartment with four seats, with two sleeping berths to draw down above them from the roof, thus affording in conjunction with the cushioned seats below sleeping accommodation for four passengers, occupies the whole breadth of the vehicle, and has a door opening into a compartment in which an attendant is in waiting. Between the two attendants' compartments a gangway runs, into which the doors of the intervening compartments for passengers open. The compartments are fitted up for four or six passengers each, and have similar, though somewhat modified arrangements for providing sleeping berths by pulling forward a couch, which, when not in use, forms part of the walls of the carriage. Each of these compartments is provided with windows and doors similar to the first-class carriages in ordinary use; but on the gangway side they open into the gangway, which in turn is provided with doors and windows opposite those of the compartments, so that the view of the passenger is not intercepted, and ventilation secured. Lavatories upon approved principles are provided, and the carriages are lighted with gas and heated with coal gas. The great recommendation of the new coaches is that while they give to passengers much freedom, they secure independence by being divided into a series of small compartments for four or six passengers each.

#### How Freight Trains are Handled.

A wildcat train used to be the dread of railroad men. Now every freight train on a great many roads is a wildcat. Yet it runs with more safety to itself and to other trains than when it used to be time-tabled. It starts out when it can, and thereafter runs or lies still on sidings under orders received at the stations.

This state of affairs has been brought about by the increasing use of and dependence on the railroad telegraph lines. But to secure safety, the telegraph must be checked out with the flag. The engineer can be communicated with only by flag or lantern. Telegraphic communication stops at the stations.

Three years ago every flagman on the Erie Railroad was summoned to the Superintendent's office, and there made to show whether or not he understood the rules of the road as to flagging trains. If it was found that he did understand them, he was allowed to go back to work after signing a statement that he understood them. It is said by road officials that this proceeding so impressed the flagmen with the importance of their duties that there has never since been an accident caused by a flagman's carelessness, such as was said to have caused the accident at Rye, on the New Haven Railroad. There are four whistle signals. One whistle, continued for about five seconds, indicates that brakes must be turned on to stop the train. Two whistles is the signal to let off the brakes. Three whistles is the signal that the train is about to be backed, and also for the flagman to go back. Whether the train is backed or not, and under any and all circumstances, the flagman must leave the caboose of a freight train or the rear car of a passenger train and hasten back three-quarters of a mile or a mile in readiness to stop any trains that may be approaching. He must stay there until he has stopped an approaching train or until he hears the signal to come back. This signal is four whistles.

When the engineer has given the signal for the flagman to come in, it by no means follows that the train must wait for him. The flagman gets back if he can. If he cannot, he must follow on the next train he can get. His flag is a pass on any train. Sometimes, when a fog lies on the Jersey meadows, an Erie train comes in with only the engineer and conductor in charge of it, every other employé having been left behind with a flag.

The signal for the flagman to go back must be given by the engineer every time the train stops, unless it be at one of its regular stations and on time. If it is not on time a flagman must be whistled back. More than this, whenever a train stops, except at a station on time, the flagman must go back, whether he hears the signal to do so or not, and he must stay there until he gets the signal to return to the train. If he does not get a signal to return, he must stay back on the track until he stops a train. The theory is, that if a flagman does his full duty, there is hardly a possibility of the crashing of one train into another. There are 130 daily passenger trains scheduled on the time tables in the Erie office. These must necessarily run according to a time schedule. Of the numerous freight trains only two are now scheduled, and it is said that this is a mere form, since it is impossible that they should run on time. The only general rule of the road as to the running of trains not carrying passengers is that right of way shall always be given to stock over all other freight.

All freight trains may be said to be run under the eye of a train dispatcher, whose business is to study the train sheet. This is a very large ruled sheet of cardboard, on which the telegraphed time at which every train on the road passes a sta-

tion is put down as soon as it is received. This sheet informs him just where every train running on the road at any given time is. Some roads make their train dispatchers out of the telegraphers in the dispatcher's office. It has been the policy of the New York, Lake Erie & Western Railroad, however, to make them out of conductors, on the principle that the dispatcher ought, in case of an accident or other disturbance of the running of trains, to be able to call up to mind every inch of the road, with every switch and siding, where the long fast time stretches, and where it is impossible to make good time. He must know where to lay up an unimportant freight train, and where to stow a stock train temporarily, so that a passenger train shall lose no time, if possible, and the stock train will lose as little time as possible.

In such a juncture the dispatcher has no time to plan. All stations are notified of the disturbance, and every moment comes a statement from one of them that such or such train is there and waiting for orders. Only one train can do the work, and a man who has not in his mind a vivid picture of the road, such as a conductor has, would find himself at a disadvantage. There is a record of the orders sent out by a dispatcher in the Erie office in case of an accident several years ago, showing that frequently during a period of eight hours the dispatcher sent out as many as three telegraphic orders a minute. The object is to keep as many of the important trains moving as possible.

In each freight caboose there is a machine which records all the movements and stoppages of the train. The revolution of an axle of the caboose moves a piece of paper, and a pencil is moved by clockwork. If the caboose stands still it records exactly at what time it stops and how long it stands, because the pencil keeps moving. If it starts, the time is recorded by a divergence in the pencil mark at a certain point upon the paper, and if it backs the paper moves backward, causing the pencil point to make a truthful record. This machine compels engineers and conductors of freight trains to perform their duty. It is not used on passenger trains, because they run by a time schedule.—N. Y. Sun.

#### New Shops of the Chicago, Milwaukee & St. Paul R. R., at Milwaukee.

This road, the numerous branches and extensions of which have been so rapidly acquired, has had a growth of traffic which is even greater in proportion than its increase of mileage. The consequent increasing demands upon the shops have been so great that their facilities have hardly been sufficient for the current repairs, and except at their North Milwaukee shops they have not been able to build any new rolling stock for some time. Last season new machine shops were built, and the old ones, including the round house, were taken to enlarge the car shops, which are still much too small, and new ones are being built near the new machine shops. The old shops, when abandoned, will be removed, and their site taken for a much-needed addition to the freight yards.

The location of the new ones is out on the river flats, about two miles from the old ones, near the Union Depot.

The switches from the main track to the new round house and shops lead past the coal sheds, which are 450 ft. long. The round house, of 44 stalls, is a complete ring, 65 ft. wide from the inner to the outer wall, and 310 ft. in extreme diameter. The turn-table in the central opening is 50 ft. long. The engines stand in the stalls with the head-lights to the outer wall, which has numerous windows, giving abundant light for working about the engines. An adjustable chimney, which hangs upon a wire rope running over pulleys, is balanced by a



weight in a box on the outer wall near the floor. This chimney has a funnel-shaped bottom end, that can be dropped down upon the smoke-stack of an engine, so that no smoke will escape into the house. These chimneys are so arranged that if an engine is pulled out without first having the chimney lifted no harm will be done to either stack or chimney.

On the side of the round house opposite the main track, are the shop buildings, all of brick, one story high and well lighted. The first one is 80 x 400 ft., with a central line of shafting the whole length; 100 ft. of the west end of this building is a wood-working and pattern shop, with seven tracks; 200 ft. of the east end is the boiler shop, with ten tracks. This shop is well supplied with tools and machinery, including a crane, a multiple drill press with four drills, a planer 18 ft. long and a Hartz & Fix machine for piecing flues. Next to the boiler shop is the tin shop about 60 ft. long. Between the tin and wood shops, in a room about 25 ft. wide, running across the building, is a drop pit worked by steam power. It stops automatically at top or bottom. In the same room is a vat for cleaning the machinery of a locomotive with lye and steam. It has a tight cover, with a pipe leading through the roof of the building.

The track from the round house leads over this pit across the transfer table and through the machine shop to the end of the blacksmith shop. The transfer pit between the building just described and the machine shop is 50 x 460 ft. The transfer table is worked by an engine and upright boiler carried upon it, which also works a wind-lash to move engines on and off the table.

The machine shop is 112 x 420 ft., having a central track the whole length, 19 pits on one side and the machinery on the other. This shop is well equipped with the latest patterns of machinery, and has an excellent tool room, which is run by the check system. All the shops and pits are heated by steam. The provision for ventilation is excellent. Fresh air is supplied from numerous covered openings outside through ventilating ducts to the steam pipes under the registers in the floor. Adjustable ventilators in the skylight provide for the escape of foul air. The shops are supplied with water from an artesian well 1,400 ft. deep, that discharges 480 gallons a minute at a pressure of 62 lbs. per square inch. With their stand-pipe only 37 ft. high, and the water continually running through the numerous cocks about the shops, they have a pressure of 8 to 10 lbs. The water pipes are laid in each pit. They use a Sellers' high pressure injector to test their boilers, with hydraulic pressure as high above the working pressure of the engine as the working pressure is above 100 lbs. After the water has run out, the boiler is filled from the shop boilers with steam of a pressure a few pounds higher than the working pressure of the boiler. All boilers are tested whenever they come into the shop, if it is more than a year since the last test. They have a small steam engine, cylinder 5½ x 8 in., with a governor and all complete, mounted upon small wheels. It is trundled about the shop to take the place of man power in boring cylinders, turning off valve-seats, drilling holes, etc. It is supplied with steam from pipes around the shop connecting with the stationary boiler, and its power is applied through a flexible shaft.

The blacksmith shop is 70 x 300 ft. and is the best ventilated shop the writer ever visited. The plan of ventilation is similar to that used in the machine shop. In the peak of the roof are adjustable ventilators the whole length of the shop for the escape of the foul air, smoke and gas. Besides the registers in the floor for the admission of fresh air, on each side of each of the pilasters for the support of the roof, about 6 ft. apart, there is a brick chimney rising about 20 ft. from the floor,

which receives air from the outside and discharges it at the top upward into the shop. These upward currents of air carry the smoke and gas of the fires out of the ventilators in the roof very quickly.

At the west end of the blacksmith shop and beside the west end of the machine shop is a store-house for iron, 60 x 120 ft. Attached to the east end of the machine shop is a two-story building 40 x 50 ft. for the offices. Opposite this, and but a few feet distant, at right angles to the shops, is a two-story building, 50 x 310 ft., for a general store-house, with the storekeeper's office at one end.

The shops are occupied to their full capacity, and already there is talk of enlarging the machine shop. They employ nearly 500 men, not including the engineers and firemen.

When the writer visited the shops, there were eighteen engines in the machine shop and five in the round house, and all except three were receiving general repairs. The boiler shop had commenced the boilers for six switching engines. They are to have four drivers, 50 in. in diameter, and no trucks, with cylinders 16 x 22 in., and are to weigh 26 tons. They will be built as fast as the current repairs will permit, and are the first locomotives which Mr. Lowry, the General Master Mechanic, has had time to build in seven years.

About 275 ft. west of the machine shop are located the new car shops which are being built. Running east and west is the transfer pit, 60 x 600 ft.; 20 ft. north of it is the paint shop, 93 x 403 ft., having 20 cross tracks; 20 ft. south of the pit is the erecting shop, 93 x 403 ft., having 20 cross tracks; 100 ft. further south is a building 80 x 353 ft., with one track running lengthwise; 100 ft. of it is the machine shop, and the rest is a blacksmith shop. At right angles to these shops, with the north end to the side of the transfer pit, is the wood-working shop, 88 x 403 ft., having two tracks running lengthwise. About 200 ft. south of the wood shops is a drying-kiln, 20 x 90 ft. A wing to the wood shop, 42 x 74 ft., is for the coal, engine and boiler rooms.

#### Some New Combination Cars.

A number of new combination passenger and baggage cars are in course of construction at the Jersey City shops of the New York, Lake Erie & Western road. Two of them have been completed and put into service, and are worthy of special mention as very superior specimens of this class of cars. They were designed by Mr. J. N. Mileham, the master car-builder in charge of the shops, and have been built under his supervision, their noteworthy features being an exceedingly handsome inside finish, commodious seats and large windows.

The cars are 52 feet long by 9 feet 8 inches wide over the body. The baggage compartment occupies about one-third of the length, and has closets, a stationary desk and drawers, and slatted and solid doors. The other portion has a seating capacity for 40 passengers, and is finished in solid ash, relieved with strips and moldings of cherry. The ceilings are of decorated wood corresponding with the sides. The seats and seat backs are of close woven rattan, and combine with the rest of the inside work to give to the interior a light, airy and cheerful appearance that is very agreeable. In one respect the seats are a decided improvement upon the ordinary kinds, the bottoms being of extra width, and concave in form instead of convex, the advantage of which will be readily appreciated by everybody who occupies them. The bottom frames can be easily taken out for cleaning. The windows are of 18 x 30 plate glass, and are provided with slatted blinds. The hat-racks are a new design in Eastlake style. The lighting is by six Hicks & Smith lamps, and the ventilation is well provided for. The outside is painted a marine color. The cars are all equipped with West-

inghouse brakes, Miller platforms and couplers and four-wheeled trucks, with 33-inch steel-tired wheels, and with four check-chains to each truck. The cost of the cars is said to be about \$4,200 each. In respect to careful design and skillful workmanship in every detail, they are highly creditable to the builders, and will prove a desirable acquisition to the rolling stock of the road. A hotel car is also on the stocks at these shops, which, when completed, will equal if not surpass any car of the kind that has yet been built in the country.

#### A Notable Private Car.

The following description of the car built for the use of the late Col. Thomas A. Scott, of the Pennsylvania Railroad, is condensed from the Philadelphia Press:

Car 120, of the Pennsylvania Railroad, was built years ago at the Altoona shops for Col. Scott's private use after he became an invalid. For many years it was used by him in his long journeys through the South and West, and has carried nearly all of the noted guests that have been entertained by the company's managers. Although long in service, it remains one of the finest specimens of workmanship these famous shops have produced. It runs on 6-wheel trucks, and the springs are of the finest steel and thoroughly tested. The exterior is painted in the standard red of the passenger coaches of the road, and is absolutely without ornament. The trucks are brown, and the wheels a bright green. The length of the car is 63 feet. Inside it has a drawing-room, private bedroom and bath, dining-room large enough for 10 persons to sit at the big mahogany table at the same time, and a kitchen furnished in a way that would satisfy the most exacting cook. The platform at one end of the car is 5 feet wide and inclosed by an iron railing, with seats for those who choose to sit in the shelter of the low side windows, with the scenic panorama gliding away in the wake of the train, for the President's car is always the rear one, while signals are made with the engineer by means of an electric bell. The drawing-room of the car resembles the cosy cabin of a yacht. There are books and writing-desks, as well as card-tables, while over the book-case a small French clock ticks sharply, even when the car is idle. The woodwork of the interior is black walnut, and the finishing something after the models of the Pullman cars. There are soft rugs on the floor, easy chairs near the walls. The drawing-room is lighted by eight windows, and at night by a middle cluster of four lamps overhead, with as many more on the side. The rigid simplicity of the exterior has not been carried out here, for the drawing-room is ornamented by solid mahogany and finished in silver and gold.

A door on one hand leads to the private room of President Roberts, and a smaller apartment, with sufficient room for a narrow bedstead which faces two windows in the opposite wall, while a second door leads to the bath. From the opposite side of the drawing-room a narrow passage-way leads to the dining-room, which is 25 feet long and about 10 wide, or the full width of the car. Above the carpet the finishing is partly in cherry, while the divans, extending parallel with the dining-table, are upholstered in golden plush. There are four unfolding beds overhead constructed on the Pullman pattern. In the dining-room, as in all the other apartments of the car, there are ventilators which may be opened in the opposite directions from which the car is moving, thus insuring plenty of pure air without causing a current through the car, while the fine wire netting covering the ventilators effectually guards against flying cinders and dust. A broad table with square corners stands in the middle of the dining-room, while on either side, by throwing



back the silk curtain, a view is had of the scenery without. Two folding doors opening from the dining-room lead to the kitchen, which is almost as large. It contains a pantry, a large kitchen range with an oven overhead, a broad table, wine-cooler and a smaller closet for dish-washing and other culinary operations. All that is visible to the eye in the finishing of the kitchen is solid wood like the rest of the car; the metallic work is of polished brass, after the style of modern yachts. Devoid as the car is of cumbersome furniture or unnecessary weight of any kind, it is said to be heavier than any of the other coaches belonging to the company.

#### A Surface Filler for Wood-Work.

When a person not familiar with the operation attempts to thoroughly fill a piece of wood, he meets with a great many difficulties in getting the surface to appear perfectly solid without a trace of grain. Indeed, until within a comparatively recent date there has been no easy and perfect method known for doing this work. If oil is used, the cells are filled by rubbing it in until a certain amount has been absorbed. A small quantity will remain in the furrows, and at first be level with the surface. As the oil dries, however, it shrinks, and ultimately there is left a series of partly-filled hollows. This accounts for the old process of applying successive coats of varnish and rubbing them down.

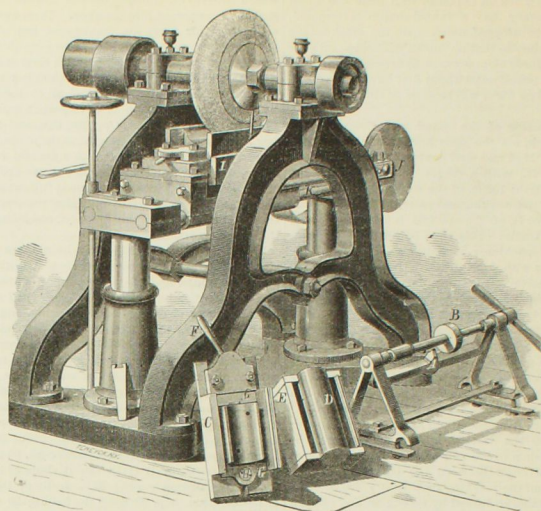
The theory was, that the varnish would ultimately fill these grooves and furrows, and by rubbing it down only so much would be removed as had adhered to the high parts. Successive varnishing and rubbing in this way consumed much time and resulted in great cost. After this preliminary work was done, the final finish had still to be applied. Accordingly much time and much money has been consumed in attempting to find a good filler, a substance which shall fill these grooves or furrows compactly and present a surface which will receive the finishing coats in a satisfactory manner. Many materials for this purpose have been employed, among which may be mentioned chalk, plaster of Paris and corn starch, all of which have been applied by mixing with oil and rubbing into the wood.

Most of these materials labor under the disadvantage of forming chemical compounds with the oil, which shrinks very much at drying, so that though the surface may appear smooth, when they are first applied, waves and hollows make their appearance as they dry.

The only material which has been found to be entirely satisfactory is ground silica, or silex as it is called in the trade. This is the material of which glass is made, and a fair result has been obtained by pulverizing, or rather reducing to powder, ordinary glass and applying it in the same general manner. The silex is mixed with oil, and in that condition probably shrinks less in drying than any other known mixture which can be used for the purpose. Silica is the basis for the best fillers now in the market.

After a good surface has been produced upon the wood-work, it is ready to receive the filler, which is to be applied and rubbed in until the surface is like so much ground glass. When the wood has reached this condition it is ready to receive the final coatings, which can be applied in the ordinary manner.—*Blacksmith and Wheelwright.*

A YOUNG nobleman in a frightful railroad accident missed his valet. One of the guards came up to him and said, "My lord, we have found your servant, but he is out in two." "Aw, is he?" said the young man, with a Dundreary drawl, but with a trace of anxiety depicted in his countenance. "Will you be good enough to see in which half he has got the key of my carpet-bag?"



IMPROVED GRINDER FOR CAR JOURNAL BRASSES.

The machine represented in the engraving is designed to supersede the use of the lathe and file, as well as of skilled labor, in the accurate fitting of car-journal brasses. This is accomplished by the use of an emery wheel, the position of which in connection with the brass is shown in the cut. These wheels are turned and kept true by a patented diamond tool, which is so arranged that it is impossible to turn by it any thing except the geometrically correct circle to which it is set. The maximum diameter of the wheels used is 20 inches, and although they may be worn down to the flange, it is claimed that they will still grind the full diameter desired, and with a speed of only 1,080 to 1,800 revolutions per minute.

The diamond tool *A* is shown in its frame, in the engraving, detached from the apparatus proper. The tool, it will be observed, swings on a center in its frame, and can be adjusted to any arc. Once set, it can only turn the prescribed arc with accuracy. In order to avoid the necessity of the foreman having to set the tool, a gauge is also furnished. This consists of a spindle adjustable with a nut in such a way that its two points rest in the centers on which the diamond tool revolves. It is only necessary for a disk *B*, turned accurately to the diameter of the bearing, to be prepared, and this the apprentice can place on the spindle, adjust the latter, and screw down the diamond tool until it touches the periphery of the disk. A nut is then fastened on the diamond tool, and the frame is lifted on the ways beneath the wheels, when the moving of the handle turns the face of the wheel to the exact circle desired.

To adjust the brass in the chuck *C* it is first set on the axle *D*. The chuck is then placed on frame *E* in such a way that the *V*s fit, handle *F* then moves a cam that clamps the brass between the jaws *G*, one set of which swing on a pivot at *H*. The brass is thus adjusted in such a manner that, despite the imperfections in molding, it is ground accurately with the least removal of metal. The chuck *C* fits into planed guides on the table *I*, and is thus brought in exact line with the motion of

the wheel. The crank *J* serves to move the table to and fro on the rods *K*, and the table also rises and falls on planed ways, being pressed up by springs. The hand wheel gives vertical adjustment to the whole bed by means of a chain beneath it. There is a pulley by which a suction fan, to remove dust, etc., may be driven. The machine is claimed to be capable of fitting from 150 to 500 car brasses per day.

The inventors and manufacturers are the Tanite Co., Stroudsburg, Pa., whose name has a world-wide reputation for the excellence of their emery wheels and grinding machines. The machine above described is only one of several of their own inventions that are specially designed for use in the mechanical departments of railroads.

#### Forcing Wheels on Shafts.

The old method of shrinking cranks, wheels, etc., to their places on shafts, or securing them by driving and keying, is now to a great extent replaced by forcing them on with a hydraulic press. The question arises, then, as to what, if any, taper should be given to the bores and axle seats.

At one of the meetings of the Master Car-Builders, this question was fully discussed. Some of the members, we believe a majority, stated that they gave a slight taper, and could not get the wheels to keep tight without it. Other members said that if the bores and shafts were parallel, with a proper allowance for forcing, the wheels remained tight, and no trouble was experienced.

Concerning the amount of this allowance, from some experiments made, it was determined that for a standard car axle the diameter of the wheel seat should be .004 larger than the wheel bore, and this would require a pressure of about 32 tons to force the wheel home.

These, we assume, are average conditions, but the smoothness of the boring and turning would have some effect in making this variable. Thus, on wheels having a bore  $4\frac{1}{4}$  diameter and 5 in. long, the axes being of steel, the rule of Mr. T. W.



Peoples, Master Mechanic of the Manhattan Elevated R. R., N. Y., is to reject wheels requiring less than about 36 tons, or more than about 35 tons to force them on. These wheels form excellent examples, because of the excessive duty to which they are subjected by reason of the frequency of their stoppage under the pressure of the vacuum brake. The practice with these wheels is to bore them parallel, finishing with a feed of  $\frac{1}{4}$  inch per lathe revolution, and to turn the axle seats taper just discernible by calipers.

This may, at first sight, seem strange, but examination makes it reasonable and plain. Let a wheel having a parallel bore be forced upon a parallel axle, and then forced off again, and the bore of the wheel will be found taper to an appreciable amount, but increasing in proportion as the surface of the hole varied from a dead smoothness. In other words, varying with the depth of the tool marks in the bore, and the smoothness of the cut.

Let the length of the wheel bore be 7 inches long, and the amount allowed for forcing be .004 inch, and one end of the wheel bore will have been forced (by the time it is home on the axle) over the length of seven inches of the axle-seat, whose diameter was .004 larger than the bore. A condensation, abrasion, or smoothing of the metal must have ensued.

Now the other end of the same bore when it takes its bearing on the shaft is just iron and iron, without having suffered any condensation. If the tool marks be deep, those on one end will be smoothed down while those at the other remain practically intact. Clearly then, for a parallel hole, a shaft having as much taper as the wheel-bore will get in being forced over the shaft, best meets the requirements. Or, for a parallel shaft or seat, and a taper hole (the taper being proportioned as before), the small end of the taper hole should be first entered on the shaft, and then when home both the axle and the wheel-bore will be parallel.

It may be remarked that the wheel-seat on the axle will also be affected, which is quite true, but the axle is usually of the hardest metal and has the smoothest surface, hence it suffers but little, not an amount of any practical importance.—*Mechanical Engineer.*

#### English Railway Carriages.

MR. M. N. FORSEY, in a letter from England to the *Railroad Gazette*, writes as follows:

"The carriages generally have either four or six wheels, 42 in. in diameter. The Midland and the Manchester, Sheffield & Lincolnshire lines are, however, using a considerable number of double truck or 'bogie' carriages, similar to those in use in America. Possibly other lines may be using them which have not yet been visited. The general opinion of the managers who are using 'bogie' carriages, as to their relative merits, if compared with those ordinarily employed, seems to be rather undecided, or, at least, is very cautiously expressed. The following statement of the weights of a four-wheeled carriage and one with six-wheeled bogies will show their relative weights. The former is 30 ft. long over the body and has two first-class and two second-class compartments and one for luggage; it will seat 12 first-class and 20 second-class passengers, or 32 in all, and weighs 11 tons 10 cwt., or 805 lbs. per passenger. The bogie carriage is 54 ft. long over body with six wheeled trucks, has three first and four third-class compartments and one for luggage, and seats 18 first and 40 third-class passengers, or 58 in all, and weighs 23 tons, or 888 lbs. per passenger, or 83 more than the other. Some English managers, like some of their brethren in America, are inclined to assign more im-

portance to a comparatively small excess of dead weight than is properly due to it. There has been a great deal of fallacious reasoning about it on both sides of the Atlantic.

"Any one who will travel in the two kinds of carriages must find that the motion of the bogie cars, whatever the merits of that system may be, certainly is much easier and pleasanter than that of the four and six-wheeled carriages, notwithstanding the fact that the English roads are ordinarily kept in such excellent condition.

"The fact that a bogie carriage rides much easier than one of the European type, with four or six wheels, is indicated also by the care with which the latter is supported on its springs. These springs are of what seems to an American inordinate length, but doubtless we might imitate English practice in this respect to advantage and to the comfort of travelers. Some of the springs on the Midland road are 7 ft. long and consist of seven plates  $\frac{1}{2}$  in. thick and 4 or 4 $\frac{1}{2}$  in. wide. It is said on this and other roads that they rarely break, although on some of the lines the inspection of them is much more rigid than it is on many lines in America.

"Double buffers near the outside of the carriages and wagons are universally used, and so are hooks for couplings instead of draw-heads. A kind of double turn-buckle arrangement, with a screw between its two parts, is used for connecting the hooks together. When the former is attached to the hooks, the screw is turned by a weighted lever attached to it, and the buffers of the two carriages are thus drawn together and more or less compressed. On goods wagons a chain of three or four links, similar to those on some of the four-wheeled cars of the Pennsylvania coal roads, is used for coupling."

#### The Dirty Locomotive.

The appearance of locomotives as regards cleanliness and the brightness of their burnished parts, together with the simplicity or the "bravery" of their ornamentation, affords the traveler quite a field for small observations on railroad management. Accustomed to think of order and cleanliness as of the nearest kin, the traveler is suspicious of the dirty condition of many of the freight engines, especially on the trunk lines, and is ready to infer bad and careless management as characteristic of the whole motive department of the road. On careful inquiry, however, he will find that the accumulation of dirt on freight engines has arisen from several diverse causes. There may be a few locomotives which are dirty from mere reckless neglect, there are many more which are neglected because of an overburden of traffic on a limited motive power; and there is not a little economical neglect of dirt and rust, a sort of principled recklessness, based either on an expensive experience of overcare, or on a great scarcity of dollars and cents.

In all cases of dirty locomotives, however, neglect is to be predicated, from whatever cause it arises. The road says in very plain terms to its men: "Let the machines take care of themselves; it is not worth while keeping the property in its best condition." The dirty engine introduces into the affairs of the road a new principle, and it violates one of the oldest and strongest associations in the human mind, namely, the kinship of order and carefulness with cleanliness. It is evident, therefore, that as an economical question, the dirty locomotive involves more items than the small wages of a few wipers.

There is, however, another aspect in which the dirty locomotive may be considered. It is a moving evidence of the difficulty with which the human mind discriminates. The freight locomotive of

to-day is dirty because its predecessor required so much care. The railroad mind has swung one full length of the pendulum, and already there are signs that it is about to stop and return to a more reasonable care of its motive power. In the West there has never been quite so much neglect in this respect as may now be found on several roads in the East. The new Western freight engine of the best type sheds brass bands and all ornamentation, and appears in a simple business suit of plain black. It is at once tasteful and restful to the eye, and easy to be kept in orderly tidiness. Nevertheless, it is not a universal favorite, and there are those, not however connected with the department of motive power, who would have the stripes and the bravery of their old-time favorites. No doubt this glistening bravery of brass and paint still serves a purpose in impressing the waiting public at the passenger station, watching with eager interest the approaching or departing train. The dirty passenger locomotive would certainly be a very poor stroke of economy.

In fact, it is a question whether the dirty locomotive pays anywhere or at any time—because it is dirty.

Every speck of more than needful dirt and dinginess costs the road somewhat that money cannot always, nor often, buy. Cheap and rapid transportation has changed many things, but among these, not human nature nor its old-time staple motives and close associations. Cheap transportation has not destroyed the connection between dirt and carelessness, nor between cleanliness and order, nor has it replaced the ideal element in human nature by any other. Men still need an outward expression of their inward ideal feeling toward their work.—*Railroad Gazette.*

AT THE Chicago shops of the Rock Island & Pacific road 20 locomotives were built during the year ending April 1, 1881, since which 6 more have been built for the road, and 2 for the Des Moines & Fort Dodge road. They have 15x34 cylinders, 57-in. drivers, and weigh 73,200 lbs., of which 46,800 are on the drivers and 26,400 on the truck. In addition to these, 3 more of the same dimensions and weight are in process of construction, to take the place of the same number of old ones that are much lighter. One of them will have a fire-box upon the plan recommended by Mr. Jacob Johann, master mechanic of the Wash. St. Louis & Pacific road, at Springfield, Ill., with an arched crown-sheet braced with stay-bolts instead of crown bars. The bolts have a nut and washer on the end under the sheet. The box will be 60 in. long, 33 $\frac{1}{2}$  in. wide, and 70 $\frac{1}{2}$  in. high at the center. The sheets are of 5-16 steel, except the flue sheet, which is  $\frac{1}{2}$  in. thick. The front flue sheet is the same, and the boiler shell  $\frac{3}{8}$  in. These engines have the Morse balanced valve and some other peculiarities.

Engine No. 3 of this road has been in freight service since June, 1878, when it was new. It has never been in the shop since, and none of the brasses except those on the cross-heads have been taken out for refitting, and these only once. Its mileage during the three years has been 115,369 miles, and it is considered good for 50,000 more before going into the shop. Its driving wheels are 57 in. in diameter and have Krupp's steel tires. Master Mechanic Twombly gives the credit of this performance to Jerry Shea, the engineer, who is constitutionally good-natured, and never gets his engine excited. Several years ago, when much fault was found with 51-in. drivers by other engineers on account of their slipping, he took one of these engines and ran it 107,083 miles before the first turning of the tires. Another with 57-in. drivers made 120,860 miles before the first turning. But No. 3 bids fair to greatly exceed this.



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## Communications.

### Friction of Bearing Surfaces.

To the Editor of the National Car-BUILDER :

Friction is the interlocking of minute projections on bearings. Under the microscope the finest cambric needle appears as rough and unfinished as a rusty piece of merchants' iron. Oil and other lubricants reduce friction because they float the surfaces apart and allow the projections to pass without touching. It follows, therefore, that an oil must be suited to the weight on the bearing—that is, it must have body enough to prevent its being forced out from between the surfaces. A light sewing-machine oil would be entirely unsuited for car axles for the above reason, while a suitable oil, owing to its heaviness and adhesiveness, would be equally unfit for light work.

When a journal cuts, it is the result of the minute projections coming into contact, like the teeth of a gear, and the stripping off of the projections is cutting. The interlocking caused by such contact leaves the surfaces in a much rougher condition than before. The projections are longer and larger, and hence the cutting progresses very rapidly after it once begins, and although more oil may be applied, it is not capable of again separating the larger projections. For heavy journals one of the best of lubricants is plum-bago, which acts by filling up the depressions and thus bringing the surfaces even. White lead, as it comes from the keg, is also very effective on new or cut journals, its heavy character tending to part the surfaces. It follows, therefore, that the function of a good lubricant is to effectively separate the surfaces of bearings.

The coefficient of friction is that portion or percentage of the weight of a body which must be exerted to move the body. This is ascertained by dividing the weight of the body moved into the force necessary to move it. Thus, if a body weighing 160 lbs. requires a force of 40 lbs. to move it, we have  $\frac{40}{160} = .25$ , as the coefficient in such case. If the coefficient of friction of a body weighing 2,000 lbs. is .25, we have  $2,000 \times .25 = 500$ , as the force necessary to move the body.

The general laws of friction as applied to metallic surfaces, when such surfaces are not sufficiently loaded to produce cutting, are that the pressure alone varies it, and that it is independent of the surfaces in contact or the velocity of the surfaces. It follows, then, that a line shaft may have a box 10 or 20 inches long, equally as well as 4 inches, so far as friction is concerned, provided the surfaces are equal in both cases and the shaft perfectly straight and cylindrical. An apparent exception to this is often cited. If we take a piece of shafting, center it and place it in the centers of a lathe it revolves very easily; but if we remove it and place it in journals it revolves much harder. It is frequently asserted that the increase of surface in the journals incites the apparent extra friction. This is not true, for the reason that when the shaft is on the centers of the lathe, we have the radius of the shaft for a lever, and the mass of metal outside of the center acting as a fly-wheel to keep the shaft in motion when once started. When in the journals there is no leverage, as the resistance of the journal is at the same radius as that at which we use our hands to revolve it.

It is generally supposed that Babbit metal and brass boxes tend to reduce friction. This also is not true, as there is less friction between a wrought-iron shaft running in cast-iron boxes than in either Babbit or brass boxes. A good steel or wrought-iron shaft, running in cast-iron boxes, will outlast the brass or Babbit boxes. But it is frequently desirable and necessary to have the

shaft suffer the least wear, in which case brass or Babbit boxes are necessary, as these generally wear faster than cast-iron boxes do, thus allowing the wear to come on the boxes, which can be renewed at less cost than the shaft. Hence, in designing bearings the surface that can be the most cheaply renewed should be the softer. All Babbit does not wear faster than wrought-iron or steel, as it is frequently the case that crank-pins are worn down, while the Babbit may be seen standing out beyond the brass in the boxes. Nine times in ten this Babbit metal is praised when it is the worst thing that can be put into the boxes, as the pin must either be renewed or turned down—a much more costly piece of work than the renewal of the boxes.

Adjustable boxes wear much faster than solid ones. Thus, on the side-rods of locomotives, when adjustable boxes are used, a great portion of the wear is due to the incessant and injudicious keying-up, the result being that the boxes are worn out and the pins badly strained. A solid box on a side-rod would last under ordinary circumstances from 18 months to two years. These boxes fitting into solid-end rods would insure a correct length of rod, and by putting the adjusting power out of the engineer's hands, would also insure a maximum of natural wear.

In reference to the pressure on bearings, it is customary to reduce it to the "projected area"—that is, the diameter of the journal multiplied by its length. This pressure varies greatly in different classes of bearings. A loaded freight car will average from 200 to 225 lbs. per square inch of journal, a locomotive driving axle from 200 to 250 lbs., while a locomotive cross-head or wrist-pin sustains a pressure of from 1,000 to 1,500 lbs. per square inch. The little trouble locomotive crank-pins give is quite remarkable, considering the high pressures to which they are subjected. The limit, however, is sometimes very closely approached. An engine pulling passenger trains on a certain road always had hot pins when climbing long grades, while they cooled off when running down grade. The heating was done away with by using new pins, with an increased diameter of only  $\frac{1}{4}$  of an inch. I would give the pressure per square inch, but unfortunately have forgotten the dimensions of the pins. The change of motion at each revolution, as occurs in the main rod, etc., allowing fresh oil to find its way between the faces of the bearings, may have something to do with the successful working of crank-pins.

One of the latest and best treatises on friction is Professor Thurston's "Friction and Lubrication," FRANK C. SMITH, M. E.

### Car Inspection.

To the Editor of the National Car-BUILDER :

Master car-builders, as well as the higher grades of railroad officials, are presumed to understand the importance of efficient car inspection, yet it must be manifest to any intelligent observer of the manner in which this service is performed that one very essential feature of it is grossly neglected. Almost everybody knows the practical value of an "ounce of prevention," and in these days, when it is no easy thing to get seasoned lumber for new cars, the familiar adage has a peculiar force. As freight cars are usually built, the least shrinkage of plates, sills or posts, loosens the braces and trusses, and although this can be prevented by the tightening of tie-rods, the remedy is seldom or never resorted to until the car is actually broken, and it may be in consequence of this very neglect. As soon as the braces become loose there is more or less motion at the joints, which increases the looseness, and it is no wonder the framing sags and breaks. The inspectors are apt to look only for breakages; and so long as none are apparent, the

cars are allowed to keep running without regard to their condition in other respects. There ought to be special provision for tightening up all new cars the second month in the summer and the third month in winter, after they are turned out of the shop; and after that, every freight car should be inspected and tightened up in the same way at least once a year, and so thoroughly that every brace, nut and washer will have a firm bearing. No pressure of business should be allowed to prevent such inspection. There can be no question as to its economy, as it would consume less time and cause less detention than to repair the inevitable breakages that would occur if it is not done.

NELSON.

### Railway Master Mechanics.

To the Editor of the National Car-BUILDER :

It may well be doubted whether there is any class of men in this country whose influence is so great in their respective spheres, and who are at the same time so undeservedly overestimated, as railway master mechanics. In most other professions and pursuits in which a certain amount of technical knowledge is necessary, as well as a knowledge of fundamental principles, a preliminary course of study is deemed indispensable. That the advantages of such a preparatory course are not as a rule possessed by the class referred to, is due to the fact that the railway system has been developed too rapidly to allow of the requisite technical training to meet the emergency.

Ask the average master mechanic of to-day why the frame of a locomotive is made of a particular size, why a smaller size would not do as well, or how he would determine the size of a frame for a larger or smaller engine, and the chances are that we should hear some pretty tall gussing. Or, if we ask an average master car-builder the same questions with respect to a car sill, there will in all probability be the same kind of gussing. But if a civil engineer is asked how he gets the size of a compression member or a tie in a bridge, he at once begins to figure, and the result will be pretty sure to stand fire, because his calculations are based on a knowledge of elementary principles. When a new engine is to be built, the master mechanic not unfrequently casts about to see what others have done, or are doing, or he follows the directions of his superior officers, who know little or nothing about mechanics or motive power. If a tender truck is to be made, does he go to work and determine the strains the truck must bear, and proportion the parts accordingly, basing his calculations on a knowledge of the strength of the material, and the strains to which it must be subjected? Perhaps so. Or, he may call his draughtsman and request him to run over to the X Y Z shops, take a good look at their tender-trucks, and get up a drawing just like them.

The directors of a road want a new passenger engine built that will pull the new Salt River express train at the rate of 50 miles an hour. Does the master mechanic in such a case take from the shelf a few select authorities on locomotive engineering and demonstrate that the resistance increases as the square of the speed, and make calculations for a proportional increase of cylinder and boiler power? Does he estimate the tractive force of the new engine, and know beforehand whether it is possible for it to perform the work? Or, does he tell his draughtsman to get out the drawings for a new engine, say 17 x 24 cylinders, boiler 50 or 54 inch shell with plenty of flues, 35½ foot drivers with 6 inches more spread than for a 51 inch boiler, and a good valve motion? However this may be, the engine is built and makes her trial trip; but when she gets down to regular duty it is found that the express train pulls too hard, or that the track is in bad condition, or something of



the kind. Any way, she never makes the 50 miles an hour.

This, I aver, is no exaggeration, nor is it surprising when it is considered that there is no standard or course of preparatory study, and but little opportunity for master mechanics to learn what is being done in other shops than their own. When new and strange conditions arise, the lack of technical knowledge leaves no alternative but to copy, if there is anything to copy from, or else resort to guessing. In marine and first-class stationary engine work every part is subjected to the most careful analysis and is correctly proportioned. The American locomotive, as a type, has been perfected by our large contract shops, where the best talent is brought into requisition. The fact is that four-fifths of the improvements in locomotive and car work originate with outsiders, who are in no way connected with railroads. One manifest drawback to the efficiency of master mechanics and car-builders is that they are subordinate to higher grades of officials who are not mechanical men, and who expect the heads of car and locomotive departments to become accomplished experts in their position by simply learning the machinist trade, then becoming a gang boss and then a foreman.

What is wanted in this country is a school where young men, after learning in a railroad shop as much as an average foreman knows, can enter and receive a mathematical and technical topping off. Then we may look, not only for an improvement in the economy of the American locomotive, but an increase of the power, capacity, remuneration and responsibility of railway master mechanics.

SUTHERLAND.

#### Patching Locomotive Cylinders.

To the Editor of the National Car-Builders:

Locomotive cylinders are frequently broken in such a manner as to allow of being patched, which, if well performed, renders them practically as good as ever. Considerable skill is sometimes necessary in this class of repairs, and especially when the fracture involves the port.

In Fig. 1 is shown a broken cylinder, the edge of the break having been chipped-and-filled beveling, as shown at *a a*. A piece of sheet iron is then bent to the circle of the cylinder inside, and placed in it so as to prevent the plaster of Paris which is

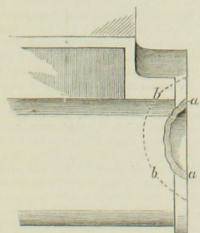


Fig. 1.

used from falling into the cylinder. A simple thick mixture of plaster of Paris and water is frequently used, although the addition of one-third of marble dust toughens the mixture and delays the "setting"—this latter feature being desirable. The surfaces of the break and side of cylinder being well oiled, and the sheet iron in place in the cylinder, the plaster of Paris may be piled on and worked down on to the surfaces to insure contact and absence of air-holes, the mass extending to the dotted line *b b*. When it is set sufficiently, it may be reduced to shape with a wet knife. The thickness of the

patch where the rivets are placed is usually from  $\frac{1}{8}$  to  $\frac{3}{8}$  of an inch. When completely set, the plaster pattern may be removed from the cylinder and retouched with a file. It may then receive a coat of varnish, and a brass casting be made from it, which should be soft enough to allow of being caulked. The joint at the fracture between the patch and cylinder need not be a "scraped joint" a fair, ordinary touching of the surfaces being sufficient. The writer has seen lugs cast on to the patch to allow of the insertion of set-screws *d d*, as shown in Fig. 2, in order to force the faces of the

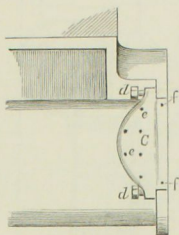


Fig. 2.

joint together. Brass rivets *c c* are inserted, and well countersunk both inside and outside. The patch is frequently allowed to extend past the fracture on the cylinder flange to allow of rivets *f f*, as shown.

After the patch is riveted into place the edge of the patch in the bore of the cylinder is caulked against the cylinder, when the patch needs only to be bored out. Fitting a wooden pattern, in place of the plaster of Paris, is frequently resorted to, but has the drawback of taking more time, and at the best, of being a far less accurate pattern.

Fig. 3 shows a portion of a valve seat with a brass patch *b*, when for any reason a patch is necessary.

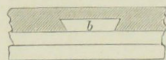


Fig. 3.

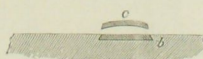


Fig. 4.

The ends of the patch are dovetailed both ways, as shown in Figs. 3 and 4. A brass patch is then got out and made the same length as the cavity in the seat. It is then bent a trifle, as shown at *c c*, so as to allow of its being placed in the seat, and then straightened out in position. This of course locks the patch in. A couple of rivets may be inserted, but if the job is well performed, the rivets will not be necessary.

FRANK C. SMITH, M. E.

#### Standard Freight Cars of a Southern Road.

To the Editor of the National Car-Builders:

The fact is paraded in some of the railway journals that a northern road, the name of which I cannot now recall, is building box freight cars 33 feet long, and with a capacity of 40,000 pounds, as if this was something extraordinary. Why, down here in Georgia 33-foot box cars are an old story. This has been the standard length for box and flat cars built for the Georgia Central road for many years past. I wish some of the Northern and Western builders could see them, and the trucks we put under them to carry 20 tons of freight. They are the lightest

cars of that capacity that I ever saw or heard of. The axle journals are  $4 \times 8$  inches, which I think is the largest car journal in use in this or any other country, and I have yet to hear of one of them getting hot—a fact that is mainly due to the increased area of bearing surface, which reduces the liability to heat to a minimum. When this size was adopted by the road, I was in favor of increasing the length to 10 inches. What a grand bearing that would be for the present 20-ton loads, to say nothing of still heavier ones that will soon be in fashion! The old idea that an increase of journal bearing surface increases friction and makes cars pull harder is pretty thoroughly exploded.

K. K.

[We wish our correspondent had stated what these cars weigh, and then the proportion of dead weight to capacity could be compared with the claims of other builders. In regard to  $4 \times 8$  journals, we believe the Philadelphia & Reading road used journals of this size on its 8-wheel coal cars ten years ago, and still continues to do so; but when the few advocates of this size urged its adoption for the "standard" axle at the meeting of the Car-Builders' Association in 1873, they were thought to be more visionary than progressive, and so a compromise was made on  $3\frac{1}{2} \times 7$ , a size which already begins to look small.—ED. CAR-BUILDER.]

#### The Rigby Car Wheel.

This newly invented wheel is thus described by the inventor: The hub, spokes, rim and side plates are cast in one piece, and answer to the unchilled portions of the common cast wheel. The tire and flange, in separate pieces, are of steel, making a wheel of three distinct pieces. The cast-iron portion is made of the toughest iron and left in its natural state. The outer rim is turned to true surface, perfectly round; the tire made of the best character of steel, with its inward and outward surface turned to a true circle, and shrunk to its place on the outer rim of the cast-iron portion. This tire is two inches thick, having a lateral bearing on the outside against the side plate, which projects to within three-fourths of one inch of the top of the tire. The flange, also of steel, rests upon the edge of the inner side plate, with absolutely true joints, both on the plate, cast rim and tire, and held to its place with sixteen seven-sixteenth inch cold drawn iron bolts passing through from plate to plate, with strong, heavy threaded nuts and rivets. The tire is a trifle wider at the bottom than at the top, and is held by the flange and outer side plate as in dovetail, and consequently cannot get out of place. Even should the tire for any cause become broken, no piece can get away from its place without breaking its lateral bearings—a thing not likely to be done.

THE car works of Pardee, Snyder & Co., at Watsontown, Pa., are being enlarged by an addition to the wood-working shop 50 by 60 ft. The blacksmith shop has been nearly doubled in size.

The machine shops of the Chicago, Milwaukee & Saint Paul Railroad, in Minneapolis, are to be torn down and built elsewhere, to make room for the proposed mammoth one million bushel capacity elevator.

THE Pennsylvania Railroad is building a patent car at the Altoona shops for the transportation of fast horses and sulkeys. One end of the car contains compartments for four horses, and the rest of the car is to be used for sulkeys, harness, etc. The new sporting stock car is intended to be attached to passenger trains, so that grooms and stock can travel from point to point with more rapidity than by ordinary freight trains. Should this car prove satisfactory, others of the same kind will be built.



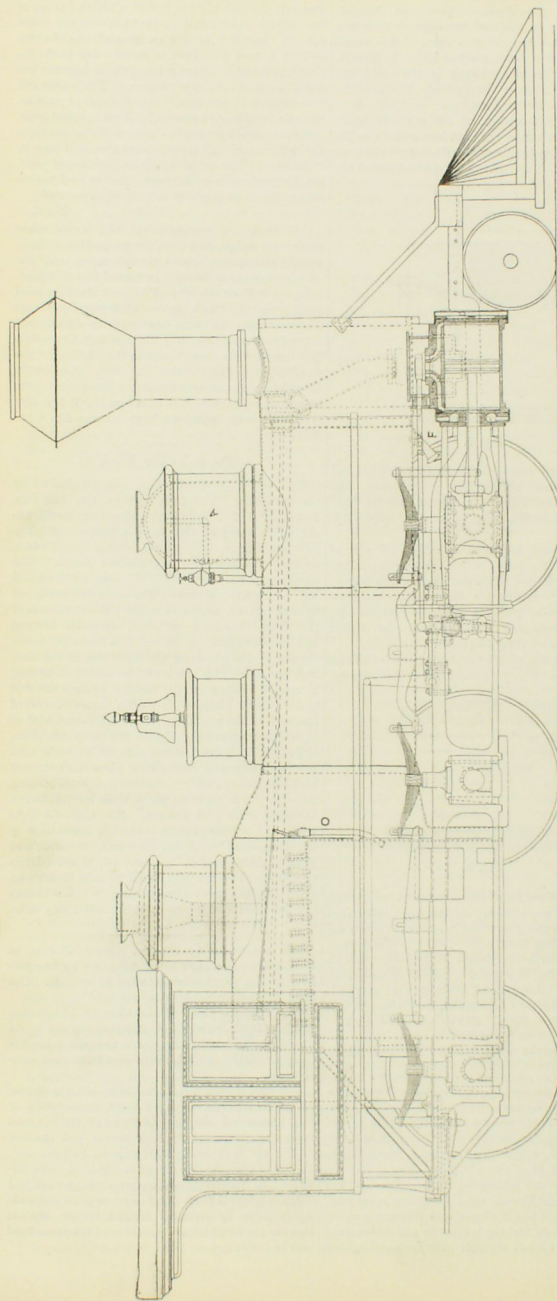


FIG. 1.—STANDARD MOGUL LOCOMOTIVE—ILLINOIS CENTRAL RAILROAD.

The engravings illustrate the Standard Mogul Locomotive of the Illinois Central Railroad, built in 1881, at their Weldon shops, Chicago, Ill. Its principal dimensions are as follows:

Boiler, smallest outside diameter.....	50 in.
No. of tubes.....	179
Diameter of tubes.....	2 in.
Length.....	11 ft. 5½ in.
Fire-box, inside.....	65 × 34½ × 65½ in.
Square feet of grate surface.....	15½
" " heating surface of fire-box.....	104
" " tubes.....	1,061
Total square feet of heating surface.....	1,165
Cylinder, diameter and stroke.....	18 × 24 in.
Driving wheels, diameter of.....	4 ft. 8 in.
Truck wheels, ".....	2 ft. 6 in.
Driving wheel base.....	15 ft. 6 in.
Total wheel base.....	22 ft. 11 in.
Journal of driving axle.....	7 × 7½ in.
Weight on driving wheels.....	68,000 lbs.
" " on truck.....	18,000 lbs.
Total weight of engine in working order.....	86,000 lbs.
Capacity of tank, water.....	2,500 gals.
" " coal.....	4 tons.
Total weight of tank in working order.....	40,500 lbs.
" " engine and tank in working order.....	122,500 lbs.

#### PREVENTION OF INCrustATION.

The incrustation of boilers by the bad water, which is the best many of the railroads can get, has made the construction of locomotive boilers so as to secure good service from them while using such water a problem of great interest to most master mechanics. This locomotive has several attachments and peculiar features that originated in the Weldon shops, some of which are especially designed to prevent incrustation and keep the boiler clean.

The first device for this purpose was a filter and lime-catcher, which takes advantage of the well-known facts, that water when heated to a high temperature deposits its lime, and that lime has a great affinity for iron. The filter, shown at A, Figs. 1 and 4, consists of a dome filled with small pieces of broken scrap iron, supported by a perforated plate B. The feed water is received through a double check C and pipe D, into the top of the dome, where it is met and heated by the steam from the boiler sufficiently to cause it to deposit the lime as it trickles through the heated scrap into the boiler. The deflectors E E prevent the sediment in the water from falling on the dry pipe and flues on its way to the bottom of the boiler, where it collects ready to be washed out.

This is done by the use of their next attachment, shown at F, in Fig. 1. In Fig. 3, the upper engraving is a part plan, the middle one a front elevation, and the lower one a vertical section of this wash-pipe. The brass fixture F is secured to the boiler shell H by four rivets. It has a hose coupling thread at the outer end, and a cap J when not in use; the inner end J has a narrow opening ½ × 3 in., through which the water is delivered in a much better way than from a hose nozzle. This wash-pipe is placed as near as possible to front flue sheet K. Its use avoids the necessity of removing the petticoat pipe and the flue sheet plug.

Their next attempt was to find a method of removing the sediment which is left on the crown-sheet by the rapid evaporation of water from over the fire-box, that would be more efficient and convenient than using a hose through the dome opening. For this purpose they constructed the crown-sheet washer represented in Fig. 5, which gives a side elevation with a portion of the boiler removed to show a section through flues, crown-sheet and crown-bars, and the position of the washer in relation to them; and also a vertical section at the location of washer in front of fire-box flue-sheet, showing the relation of the holes L in pipe M, to the crown-bars and bolts. This pipe extends across the boiler, the inner end being closed, and it has oblong holes L opposite all the spaces between the rows of crown-bolts. The check N is provided with a pipe O, having a hose attachment at the end. This pipe O is carried through the running-board to any place convenient for attaching the hose, and to be used as a discharge pipe. The valve stem P of the check N has a bell-crank Q connecting with the rod R, which extends to the cab, enabling the engineer to use this arrangement as a surface cock to prevent priming, foaming or excess of water in the boiler.

Their method of washing the boiler, which experience has shown to be the best, is as follows: The hose from



OCTOBER, 1881.

the Standard Mogul Locomotive, built in 1881, at III. Its principal dimensions

.....	50 in.
.....	179
.....	2 in.
.....	11 ft. 5½ in.
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.....	18 + 24 in.
.....	4 ft. 8 in.
.....	2 ft. 6 in.
.....	15 ft. 6 in.
.....	22 ft. 11 in.
.....	7 + 7½ in.
.....	68,000 lbs.
.....	18,000 lbs.
.....	86,000 lbs.
.....	2,500 gals.
.....	4 tons.
.....	49,590 lbs.
.....	192,560 lbs.

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The feed water is re-  
and pipe 11, into the  
t and heated by the  
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heated scrap iron to  
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where it collects ready

their next attachment, the upper engraving is at elevation, and the wash-pipe. The outer shell *H* by four and at the outer end, the inner end *J* has a which the water is from a hose nozzle. possible to front five of removing the

method of removing crown-sheet by the cover the fire-box, than using a for this purpose they represented in Fig. is a portion of the rough flues, crown- of the washer in cal section at the flue-sheet, showing, to the crown-bars the boiler, the inner holes *L*, opposite crown-bolts. The a how attach rried through the ent for attaching e pipe. The valve ank *Q* connecting ab, enabling the surface cock to of water in the

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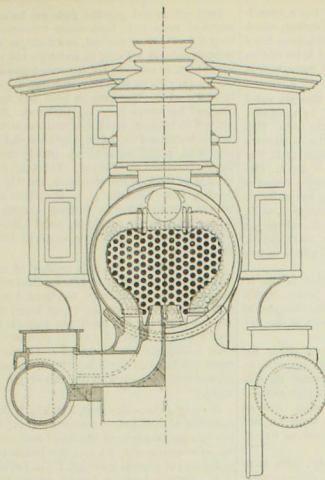


Fig. 2.—Front Elevation and Section.

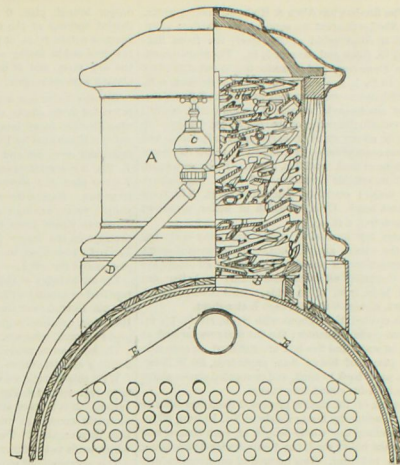


Fig. 4.—Filter and Lime-Catcher.

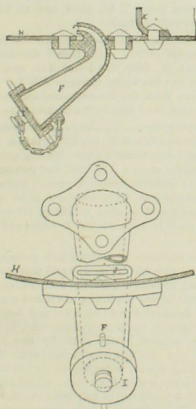


Fig. 3.—Front Wash Pipe.

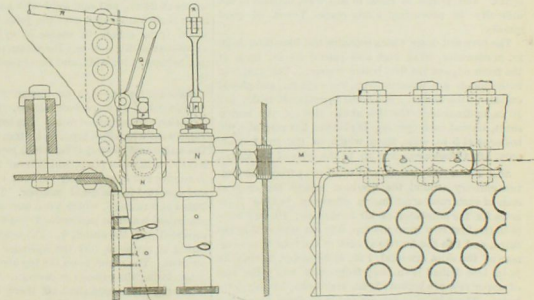


Fig. 5.—Crown Sheet Washer and Surface Cock.

The force pump is attached to pipe *O* of crown-sheet washer while the globe cock in the line is blowing off the steam, and water is immediately pumped in until the boiler is full, which gradually cools off the water and boiler and prevents the sediment from settling and hardening. Without stopping the pump, the hand-hole plates are removed and the pressure of the force pump is raised so that the water will be forced through the crown-sheet washers over the crown-sheet through the openings in crown-sheet washers until the crown-sheet is sufficiently washed, when the hose is removed to the front wash-pipe *F*, and the waist of boiler cleaned. This continual injection of water under pressure while the boiler is being emptied, keeps the mud and sediment in constant circulation until it is blown off the boiler. The water is then cooled off, and there is not time to cool it off, the injectors and pumps are kept working, and the crown-sheet washers draw off the surplus until the water is changed. An en-

gine just out of the shop, which brought in a train of three passenger cars with difficulty, was blown out in this way without cooling her fire, and in three-quarters of an hour after coming in took out a train of eleven passenger cars with ease. One of their orders to engineers is to use the crown-sheet washer as a surface cock once an hour while the engine is working, and whenever there is foaming or priming.

These improvements are of too recent date to have demonstrated their full value, but their use has reduced the cost of boiler repairs more than 50 per cent., besides increasing their durability and securing a saving in the amount of coal burned per car mile. The first engine to which the filter was applied made a mileage in Illinois of 99,464 miles in three years before the flues were removed. On the Iowa division, which has the worst water, the average time between the removal of more than 100 flues from the boiler was 7½ months in 1879, before the application of any of the improvements. In May and June, 1880, three heavy Moguls, and in October, three more, all having these improvements, were put in service on this division. These engines have run from 10 to 14 months without giving

any trouble from sediment, and the boilers are in good condition.

The Filter, Crown-sheet Washer, Cylinder Cock and Throttle Valve used in this locomotive are patented. Further information in regard to them may be obtained of S. J. Hayes, Supt. of Machinery, Illinois Central R. R., Chicago, Ill.

## DETAILED DESCRIPTION.

*Flue-plate.*—Of 0.01 steel  $\frac{1}{8}$  in. thick, except the flue-sheet, which is  $\frac{1}{16}$  in. The inside dimensions are: width at bottom, 34½ in.; at top, 48½ in.; length, 65 in. height at front, 65½ in.; at back, 68½ in.; the crown-sheet having a slope of 2 in. The fire-door opening is 18 × 17½ in. oval, formed by flanging both sheets outward and connecting them by a ring made of the same steel, as shown in fig. 1. The water spaces are 3½ in. on the sides and back, and 4 in. on the front, and formed by a wrought-iron flange of 3½ in. iron between box and flue-sheet, and 4 in. between the flue-sheet and crown-sheet, 1½ in. apart from center to center. Five braces from the flue-sheet extend to the boiler-sheet in the usual way, except that the rivets have thimbles 1 in. long made of ½ in. iron, between the crown-sheet and the flue-



sheet. The fire-box has Allen & Hudson's slaking grate.

**Boiler Shell.**—Except the smoke-arch which is charcoal iron) is constructed of Otis steel; the front flue-sheet is  $\frac{1}{2}$  in. thick and the rest  $\frac{3}{8}$  in. The main dimensions are: From front end of smoke-box to out of fire-box forward, 14 ft.  $\frac{1}{2}$  in.; length out to out of fire-box, 6 ft. 2 in.; width out to out of fire-box at bottom, 3 ft. 8 $\frac{1}{2}$  in.; length of smoke-arch, measured outside, 2 ft. 8 $\frac{1}{2}$  in.; smallest outside diameter of barrel, 50 in.; wagon-top raises 10 in. above sheet of barrel next adjoining, and the bottom connection-sheet lowers 3 in. below the same. Total height of back head 7 ft. 5 $\frac{1}{2}$  in. Dome on wagon-top of 26 in. outside diameter, and 26 in. high above shell of boiler; center of dome to be 3 ft. 8 in. from face of back head. Greatest width of boiler, measured over wagon-top, 4 ft. 4 $\frac{1}{2}$  in.

All holes for horizontal seams and stay-bolts are drilled; the others are punched. The horizontal seams in connection-sheets are double riveted; all others are single. Covering all horizontal seams in boiler are welts of  $\frac{1}{2}$ -in. iron, 12 in. wide, with 4 rows of rivets, 5 in. apart, zigzag, 2 rows in each boiler-sheet.

Shell is riveted throughout with  $\frac{5}{8}$ -in. rivets, 1 $\frac{1}{2}$  in. apart from center to center; the flat surfaces formed at junction of waist and fire-box are stiffened on each side by four pieces of heavy 3-in. angle-iron, 36 in. long, placed in pairs back to back, and connected across above the tubes by 1 in. round iron braces.

The bottom of the shell is protected from corrosion or mechanical action by lining sheets of No. 10 iron, 30 in. wide, extending the whole length of each course, and riveted to the boiler shell, the joints under them being filled with red lead. This method of construction prevents the pitting of the steel sheets, and thereby greatly increases their durability.

Entirely across the flat surface of the boiler-head, just above the crown-sheet, is placed a T-iron, formed by putting 2 pieces of heavy 3 in. angle-iron together, which is fastened to the shell with  $\frac{5}{8}$ -in. rivets, 6 in. apart. The T-iron is made in this way, because of the difficulty in procuring ready-made T-iron of good quality.

The forward dome which contains the lime-filter is 26 in. in diameter, 30 in. high and placed 37 in. back of the front edge of the first boiler course. The rings of both domes are wrought-iron, 2 $\frac{1}{2}$  × 2 $\frac{1}{2}$  in., and placed outside of the domes. The dome openings in boiler are 16 in. in diameter. On the under side of the boiler-sheet, around each opening, is placed a flat ring of  $\frac{5}{8}$ -in. boiler steel 5 in. wide, from which, in the front dome only, are 4 braces running up to the sides of the dome.

**Stay-Bolts.**—The second and third rows from the bottom entirely around the fire-box, except the ones at ends of each row, are 1 in. in diameter, having  $\frac{1}{8}$ -in. holes for the admission of air to the fire; 10 stay bolts 4 in. in the first row from the top, 3 in the second, 2 in the third, and 1 in the fourth) at each of the four upper corners of the sides are solid, 1 in. in diameter, having an  $\frac{1}{2}$ -in. hole drilled  $\frac{1}{2}$  in. deep from outer end; the rest of upper row are hollow,  $\frac{3}{8}$ -in. stay-bolts, having  $\frac{1}{8}$ -in. holes. These holes at top are put in to show breakages by leaking. All other stay-bolts are  $\frac{3}{8}$  in. in diameter and solid. Across the boiler, between the crown-bars, are two rows of  $\frac{3}{8}$ -in. long stay-bolts the under side of the lower row being even with the bottom edge of the crown bars, and the top row 4 $\frac{1}{2}$  in. from center to center above the other. All stay-bolts are of the best Uster iron, and placed 4 $\frac{1}{2}$  in. apart, horizontally, and 4 $\frac{1}{2}$  in. vertically, between centers. All holes for stay-bolts are drilled.

**Crown-Bars.**—Are 12 in number, made of two bars of  $\frac{3}{4}$  × 4 in. iron, welded in pairs at each end with an inch piece between, having 2 $\frac{1}{2}$ -in. bearings on side sheets. There are nine  $\frac{3}{8}$ -in. bolts with square heads to each bar; each bolt lies between head and crown-bar a  $\frac{5}{8}$ -in. washer 2 × 3 $\frac{1}{2}$  in., with a lip turned down over each side of the crown-bar to prevent their spreading, and is tapped into the crown-sheet, and has on the under side a  $\frac{3}{8}$ -in. nut,  $\frac{1}{2}$ -in. thick, all as shown in Fig. 5. In screwing in bolts great care is taken to keep the crown-sheet straight and of uniform tension. The spaces between crown-bars and crown-sheet are 1 $\frac{1}{2}$  in. high, with no washers on any bolts. The crown-sheet is braced to wagon-top and dome in the usual way.

**Steam Pipes.**—Are oval, 4 $\frac{1}{2}$  × 6 in. inside, with ball-joint connection to cylinder and throttle box. The dry pipe is of wrought iron, lap-welded, 6 in. outside diameter, with ball-joint on front end and cast-iron shoe with brass stuffing box on back end at the boiler head. The

copper branch pipe, 6 in. in diameter, has a funnel-shaped opening at the top 12 in. in diameter, which reaches within 10 in. of the dome cap; the bottom has a cast-iron saddle fitting on to a perforated brass seat on the dry pipe, and is held to it by two wrought-iron clamps with set screws.

**Throttle Valve.**—A horizontal balance throttle valve is located in the smoke-arch and operated by a rod running directly to an eccentric lever in the cab. This valve is illustrated by Figs. 6, 7 and 8. Fig. 6 shows a front half elevation and half section through *O D*, Fig. 7, Fig. 8 is a vertical section through *A B*, fig. 6. Fig. 7 gives plan and elevation of valve proper removed from box. Except the openings *G*, it is an ordinary poppet valve, having seats *E F*. The openings *G*, *G*, *G*, *G*, admit steam from boiler to cavity *H*, where the pressure on the larger seat *E* keeps the valve closed. The rod *I* is secured to valve by die *K* (made in two pieces) and the nut *L*.

The advantages of this throttle are: That it can be repaired or ground without opening the boiler; that a throttle located near the cylinders is better than one in the dome, and that it gives the full capacity of the dry pipe in a small compass.

The box can be made to take the place of either the flat or V throttle valve usually located in smoke-arch.

With this throttle valve is used the eccentric throttle lever represented in Fig. 9, which shows a plan and elevation. *M* is a brace attached to boiler head. *N* is an eccentric secured to and moved by the lever *O*, and both turn on pin *P*. The strap *Q* is fastened to rod *H*, which leads to the throttle valve.

This arrangement moves the valve easily, holds it in any position without fastening the lever, gives an easy, regular and positive movement to the valve, and permits a gradual admission of steam to the cylinders, that enables an engineer to start a passenger train without any jerk or jar.

**Cylinders.**—Are 18 in. in diameter and made for a stroke of 24 in., and cast solid with half of the bed-castings; their total length over the joint is 31 in.; the distance from center to center of cylinders, 7 ft. The valve-seat is 12 $\frac{1}{2}$  × 17 in.; the steam ports are 1 $\frac{1}{2}$  × 15 in.; bridges, 1 in. wide, and the exhaust port 2 $\frac{1}{2}$  × 15 in.

**Cylinder Cocks.**—Are an improved pattern, being a valve worked by an eccentric lever. Fig. 10 shows an elevation and section of same. The brass valve *a* is provided with wings *b* on top, on bottom and a steel stem *d*. The valve seat piece *e* is forked to receive an eccentric lever *f*, with pivot pin *g*, which lever in turn is forked to receive rod *h*, extending to both cocks on cylinder and operated in the usual manner. The seat *e*, is inserted in a casing *i*, which has a cavity *j*, to allow the condensed water to pass around head of valve, and is provided with the outlet, *k*. The length and size of this casing is made to suit the cylinder into which it is screwed. The wings *b*, on the top are to keep the valve from closing the passage in casing *i*. When the engine is moving with steam shut off there is a tendency to form a vacuum in the cylinders, then the valves will raise automatically and by admitting air destroy the vacuum and thus tend to prevent sparks from being drawn in through the exhaust ports. These cocks are cheap in construction and repairs, the valves being the only parts that require renewing.

**Pistons.**—Are made in one piece 4 $\frac{1}{2}$  in. wide, bored out to lighten them, and provided with two expansion rings  $\frac{3}{8}$  ×  $\frac{1}{2}$  in. Piston-rod is of steel, 3 ft. 2 $\frac{1}{2}$  in. long between shoulders and 3 in. in diameter, with a taper fit and shoulder in cross-head, secured with a steel key  $\frac{1}{2}$  × 2 in.; piston is put on with a taper fit and nut with end of rod riveted over. Jerome patent packing is used on all piston-rods and valve-stems.

**Guides.**—Are of iron, case-hardened, two on each side, one above the other, 4 ft. 10 $\frac{1}{2}$  in. long, 4 $\frac{1}{2}$  in. wide, 3 in. thick in the middle and 2 in. at the ends, and secured to the back cylinder-head by guide-blocks 3 $\frac{1}{2}$  in. long, and to the guide-yoke by bolts through the feet on end of guides.

**Guide-Yoke.**—Is of wrought iron, varying from 5 $\frac{1}{2}$  to 7 $\frac{1}{2}$  in. wide and 1 $\frac{1}{2}$  in. thick; made in one piece running across the frames and fastened to them by wrought-iron brackets.

**Cross-Head.**—Each consists of a cast-steel hub or center which receives the piston-rod, inclosed by two wrought-iron plates, between the edges of which are bolted two cast-iron bars to carry the brass gibs, which are 19 in. long and same width as guides.

**Rods.**—Main and parallel rods are hammered iron; length of main rods from center to center is 7 ft.; the body is 2 × 4 $\frac{1}{2}$  in. at one end, and 2 × 3 $\frac{1}{2}$  in. at the other; the stub ends are 3 $\frac{1}{2}$  × 5 $\frac{1}{2}$  in. and 2 $\frac{1}{2}$  × 4 in. respectively. Front parallel rods are 7 ft. between centers, of uniform section, 1 $\frac{1}{2}$  × 3 $\frac{1}{2}$  in. with back stub end, 2 $\frac{1}{2}$  × 5 $\frac{1}{2}$  in., and front 2 $\frac{1}{2}$  × 4 in.; the strap on back end has a "spade handle" for connecting the back rod. Back parallel rod is 8 ft. between centers, of uniform section, 1 $\frac{1}{2}$  × 3 $\frac{1}{2}$  in. back stub end 2 $\frac{1}{2}$  × 4 in., and front end has a forked jaw with a 2 $\frac{1}{2}$  in. steel pin fitting into "spade handle" on front parallel rod. Thrusts on all the rods are 1 $\frac{1}{2}$  in. thick on the stub ends, and 1 $\frac{1}{4}$  in. front of brasses, thus allowing  $\frac{1}{8}$  in. shoulder, so that new brasses can be fitted in without closing the straps. Straps all held by two  $\frac{3}{8}$ -in. bolts. Main rods have single keys, and parallel rods single at front end and double at the other.

**Driving Wheels.**—Are 6 in number, of cast-iron centers tapering from 50 $\frac{1}{2}$  to 40 $\frac{1}{2}$  in. diameter, with steel tires of 3 $\frac{1}{2}$  in. thickness on the tread, bored to fit centers and held on by twelve 1 $\frac{1}{2}$ -in. bolts; the length of the hub is 7 $\frac{1}{2}$  in.; the main pin journals are for main rods 4 $\frac{1}{2}$  in. long and 4 $\frac{1}{2}$  in. in diameter, for parallel rods 5 × 3 $\frac{1}{2}$  in.; front and back crank-pins are 3 × 3 in.; crank-pin holes are bored tapering  $\frac{1}{4}$  in. and pins ground in, and held by nuts with the end of pin riveted over them.

**Driving Axles.**—Are steel, 5 ft. 9 $\frac{1}{2}$  in. long over all; diameter of main axle at center is 6 $\frac{1}{2}$  in.; of the others, 6 $\frac{1}{2}$  in.; the diameter of the wheel seat and journal is 7 in., of eccentric seat, 7 $\frac{1}{2}$  in.; the length of wheel seat is 7 $\frac{1}{2}$  in.; of journal bearings, 7 $\frac{1}{2}$  in.; of eccentric seat, 9 in.; distance between face of driving-wheel hubs is 4 ft. 6 in.; over hubs, 5 ft. 8 $\frac{1}{2}$  in.

**Driving Boxes.**—Are cast iron, with 5 brass gibs cast in, as shown in Fig. 1. These gibs extend the entire width of the boxes and are 2 in. wide; the center one is 1 $\frac{1}{2}$  in. thick, and the others 1 in.; Babbitt metal is run in between them  $\frac{1}{2}$  in. thick, and all bored 7 in. in diameter to fit journals.

**Frames.**—Are of the best hammered iron; each frame is composed of two parts bolted together; the upper part is 4 $\frac{1}{2}$  in. deep, the lower 2 in. and the forward part 4 $\frac{1}{2}$  in.; the width throughout is 3 $\frac{1}{2}$  in. The pedestals are made for one stationary shoe, and one movable wedge, the latter on the backward side.

**Carrying Gear.**—Equalizers are hammered wrought iron, pivoted on a steel key fitted into a wrought-iron stand attached to the frame. Driving springs are made of 12 leaves of  $\frac{3}{4}$  × 3 in. steel, and measure 34 in. from center to center of spring hangers. Expansion buckles are wrought iron, 18 in. wide and  $\frac{1}{2}$  in. thick, fitted to the frames and secured to side of fire-box by twelve  $\frac{3}{8}$ -in. studs in each buckle, 6 above and 6 below the frame.

**Valve Motion** is the shifting link motion. The skeleton links, slide-blocks, saddles and pins are of hammered iron and case-hardened; the rocker-arms are of cast steel; the lifters, the lifting shaft and eccentric blades, are of hammered iron; all bolts and bearing-pins have steel bushings; the eccentrics are solid, have 5 in. throw and are secured to the shaft by two  $\frac{3}{8}$ -in. steel set-screws and one taper-fluted steel key. The valves are 17 in. long, 8 $\frac{1}{2}$  in. wide; the inside cavity, 15 in. long and 4 $\frac{1}{2}$  in. wide; have  $\frac{1}{2}$ -in. outside and  $\frac{1}{8}$ -in. inside lap and 5-in. travel at full link; the face of the links, 2 $\frac{1}{2}$  in. wide. Distance from center to center of blade-pins is 11 $\frac{1}{2}$  in.; radius of link, 50 $\frac{1}{2}$  in.; extreme length of link, 32 $\frac{1}{2}$  in.; length of rocker-arm, 10 in.; lifter, 14 $\frac{1}{2}$  in.; lifting-shaft arm, 18 $\frac{1}{2}$  in.; from center of main shaft to center of lifting-shaft, 32 $\frac{1}{2}$  in.; to center of rocker box, 50 $\frac{1}{2}$  in.; the lifting-shaft centers vertically, is even with the top of frame; the rocker arm is 6 $\frac{1}{2}$  in. below top of frame.

**Trucks.**—Are Jewell's patent truck with two fluted taper rollers, with cast-iron spoke wheels, 30 in. in diameter. Journal-bearings 10 in. long, 5 in. in diameter.

**Pilot.**—Is made of diagonal or sloping bars resting their lower ends upon the upper one of two horizontal bars which form the bottom of the pilot, all as shown in Fig. 1.

**Running Boards.**—Are of 3-16 in. wrought-iron plates, with a 2-in. angle-iron riveted on front edge, secured to the boiler shell by wrought-iron brackets.

**Injectors.**—On each side is one of Friedman's No. 7, non-lifting, old style injectors and no pumps.



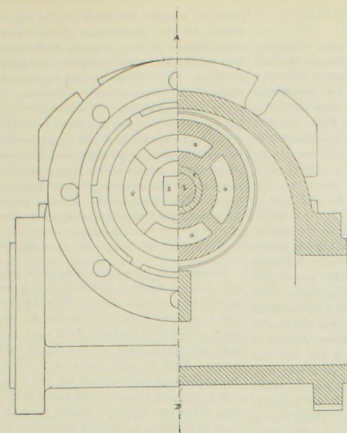


Fig. 6.—Throttle Valve.

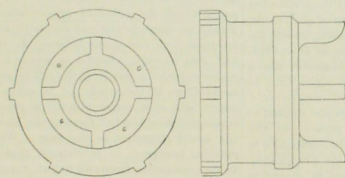


Fig. 7.—Throttle Valve.

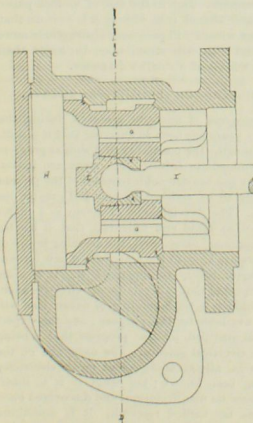


Fig. 8.—Throttle Valve.

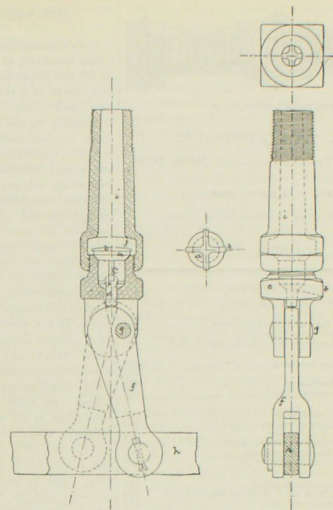


Fig. 10.—Cylinder Cock.

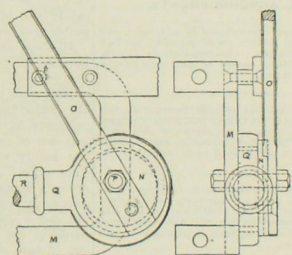


Fig. 9.—Eccentric Throttle Lever.

The New York Central road receives coal for its own use and for shipment, from its Geneva branch. At the junction with the main line at Lyons, N. Y., is an extensive yard in which the coal on its arrival is assorted and transferred both for shipment and for use in engines. The chutes are reached by a track of easy grade over a long trestle upon which the coal is carried high enough to be dumped three times, first from the cars which bring it from the mines into the sheds, then from the sheds to the dump cars which carry it to the engines, and then from these cars to the engine tenders. A "Z" switch from the top of the trestle takes the cars over the chutes and sheds through which the coal is transferred to flats or other cars for further shipment, and when unloaded runs them by gravity down into the yard. The dumping shed for supplying locomotives is built across six tracks, and the water-pipes are so arranged in relation to the chutes that four engines headed either way on the main tracks take coal, water and

sand at the same time, and in 2½ minutes, without disconnecting them from the trains. The sand is dried by steam from the same boiler that furnishes steam for pumping the water, and is elevated into the coaling sheds and supplied to the locomotives through chutes. There is a very convenient arrangement of tracks for running the dump cars between the sheds and the chutes where the engines are supplied, the tracks crossing the scales upon which the weighing is done. They are so placed about the dump-holes that several cars loaded with different qualities of coal can be kept ready, and when an engineer calls for either one, two, three or four tons of coal, a car loaded with requisite quantity can be run over the dump hole at once and emptied into the tender. Mr. Jas. Tillinghast, Assistant to the President of the company, and Mr. Charles J. Fisher, Chief Engineer, visited all the principal coal chutes of other roads, and then planned this one, which is the only one of the kind in the country.





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### EDITORIAL ANNOUNCEMENTS.

**Addresses.**—Business letters should be addressed, and drafts and money orders made payable, to THE NATIONAL CAR-BUILDER. Communications for the attention of the Editor should be addressed EDITOR NATIONAL CAR-BUILDER.

**Advertisements.**—Nothing will be inserted in this journal for pay, EXCEPT IN THE ADVERTISING COLUMNS. The editorial department will contain our own views and opinions; and the rest of the reading matter, aside from advertisements, will be such as we consider of interest to our readers.

**Contributions.**—Articles relating to railway rolling stock construction and management, and kindred topics, by those who are practically acquainted with these subjects, are especially desired. Also early notice of changes in railroad officers, organizations and names of companies.

**Special Notice.**—As the CAR-BUILDER is printed and ready for mailing on the last day of the month, advertisements, correspondence, etc., intended for insertion, must be received not later than the 25th day of the month.

**SUBSCRIPTIONS** to the CAR-BUILDER will be received, and copies kept for sale, at the following places:

A. WILLIAMS & Co., 283 Washington Street, Boston, Mass.  
L. SCHAFFNER, Cigar and News Dealer, Grand Pacific Hotel, Chicago, Ill.  
WILLIE H. GRAY, 306 Olive Street, St. Louis, Mo.  
ROBERT CLARKE & Co., 65 West Fourth Street, Cincinnati, Ohio.

SINCE the last number of our paper was issued, the land has been shrouded with the emblems of mourning expressive of the universal sorrow for the loss of the nation's chief magistrate, and abhorrence of a crime that will ever remain an ineffaceable blot on the page of history. It is not the province of a technical journal to note current political events, however startling and momentous, but the diabolical act perpetrated on the 2d of July, with its shocking sequel, may well form an exception. We need not say more; it would be a culpable omission to say less.

### PASSENGER CAR CONVENIENCES.

Notwithstanding the completeness, comparatively speaking, of our railway passenger coaches in all the requirements of convenience and comfort, there is a constant demand for something more and better. These demands crop out quite frequently in the newspapers, and while some of them are reasonable enough, there are others that are extravagant and even absurd. The ease-loving voluptuary would doubtless prefer a velvety, self-adjusting, self-rocking reclining chair to the ordinary reversible seat, in which he is obliged to sit bolt-upright when the other half of it is occupied—or, perhaps a swinging hammock would at times be more agreeable in mitigating the worry and weariness of traveling. Many other desirable things might be suggested to make passengers more comfortable. Some kind of railway car-fan worked mechanically, so as to produce an artificial breeze in hot weather, would not come amiss, and even outside awnings to the windows, instead of slatted blinds and curtains, to keep out the sun without obstructing the view. A perfectly uniform temperature combined with ample ventilation, and both graduated to suit all physical conditions at all seasons, is another thing that is wanted; also convenient places for stowing away hand-boxes, bird cages, valises and bundles large and small, where they would not be in any body's way. Station and speed indicators are wanted in every car, as well as some feasible method by which passengers may know with the least possible delay the reasons for irregular stops between stations, and the probable duration of such stops, without the trouble of guessing or asking questions. A head-rest attachment to seat-backs is wanted, that can be raised or lowered at pleasure; also a steady and brilliant light in the night time to enable aged people to read fine print—and so on.

All these and many more things are wanted to promote the comfort of railway passengers, and it is certainly for the interest of the companies to provide such conveniences as far as practicable. But unfortunately there is a limit to inventive ingenuity in this direction, imposed by the nature and uses of the vehicle itself. Reasonable people can hardly expect to traverse the continent at "cut rates," and at express speed, in a car of ordinary dimensions seating fifty persons, without dispensing with some of the luxuries of home life and a stationary abode. This may seem a hardship, but it can only be avoided by keeping out of cars altogether. Time was, and not very long ago either, when princes and potentates would have been more than content with the most ordinary facilities of railway travel as now existing, even leaving speed out of the account.

While we would not underrate the unavoidable discomforts incident to railway traveling, nor exonerate car-builders from blame for any remissness on their part in relieving these miseries, we would suggest, what the great majority of people know already, that much of the infelicity of this kind of traveling is due to a lack of courtesy and mutual respect among passengers themselves, many of whom are apt to forget that one occupant of a car is for the time being as good as another, provided he has paid his fare and does not make himself personally offensive. Locking the seat-backs so they can not be reversed at will, is an excellent thing, and prevents many a well-dressed hog from reposing his hoofs on the cushion of the next seat, which has just been occupied, and perhaps soon will be again, by ladies in elegant apparel. But while locking the seats prevents this particular abuse, it favors the practice of another incivility equally reprehensible. We refer to the habit which has become very common with young men, and even with men that are not young, of bracing their knees, in order to get into a reclining

position, against the back of the seat in front of them, to the annoyance of its occupants, and especially so if they happen to be ladies. Each seat is for the time being the exclusive property of those who occupy it, and any interference by others is an unpardonable rudeness. These will serve as specimens, without referring to other improprieties that are practiced in railway cars.

Car-builders can do much by mechanical devices to make a journey pleasant and enjoyable to passengers, but no inventive ingenuity or code of regulations can enforce civility beyond a certain limit. The rest depends on the patience, self-denial and good breeding of the individual.

### PAPER WHEELS AND AXLE SERVICE.

*Engineering* (London) refers to a paragraph in our August number in which it is stated that the record of car axle service kept by the Pullman Car Company since 1874 shows no broken axles upon which paper wheels were used, and suggests that an explanation of the fact would be interesting. This we will endeavor to furnish according to the best information we can obtain.

It is claimed that the difference in the construction of the two kinds of wheels (iron and paper) is such as to cause a material difference in the strain upon the axles, the strain being comparatively less in the case of paper wheels. It is admitted that in both cases the wheels are pressed on with the same average pressure, so that in this respect there is nothing to favor the axle in the one class of wheels more than the other. But with the paper wheel, the solidified paper—which is apparently as hard, heavy and unelastic as metal—is interposed as a medium between the tire and the hub, and as such, absorbs or lessens to an appreciable extent the jars from the rail joints and other inequalities of the track; or, in other words, the paper acts as a non-conductor in preventing the transmission of the full force of the blows through the wheel structure to the axle. With the iron wheels, however, it is claimed that the metal being continuous from tire to hub, there is nothing to relieve the axles from the full impact of the blow of the wheel upon the rail, and the result is to produce crystallization at an earlier stage of service and consequent liability to break. This is the theory, and it seems to be a plausible one, supposing the wheels in both cases to be of the same diameter. But in the case of 42-inch paper wheels and 33-inch iron wheels, it is obvious that the larger wheels will pass over obstructions more easily and with less strain upon the axles than will the wheels of a smaller diameter.

### PROGRESS OF ELECTRICAL SCIENCE.

The progress of scientific research during the last fifty years has been so amazing that it is difficult to imagine the possibility of a similar progress in the immediate future. Yet there are indications that the boasted achievements of the present are likely to be eclipsed by new and greater discoveries. The development of steam as a motor has been so rapid and universal, that it has become common place, and the teeming brains of inventors are busy in the search for a new force of still greater utility to supersede it. It is more than suspected that other and more effective agencies lie hidden in the laboratory of nature that will yet be available for this purpose; and this expectation is justified by the progress that is being made in electrical science. The existence of the mysterious, all-pervading agent called electricity has long been known; but what it is in itself, aside from its manifestations and discovered uses, has thus far baffled research. It is something which can not be analyzed. It has been conjectured by some that it may be the principle of life, or something akin to it of which the finite intel-



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## THE NATIONAL CAR-BUILDER.

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lect can attain no positive knowledge. Its manifestations, however, are constantly bringing to light new and startling facts. With respect to its utility in supplying the wants of human existence, a vast and unexplored field of discovery is beginning to be opened up. We already know something of its capabilities as a means of transmitting intelligence independently of time and space. Its service in this respect has become a prosaic fact of daily experience, so much so, that to dispense with the telegraph would be like going back to original chaos. In a kind of feeble, experimental way, it already plays an important part in mechanics, in the treatment of diseases, and in the generation of heat and light. Its illuminating power is being rapidly developed in the face of obstacles that at first seemed quite discouraging. It is a thing of use, and not a curious toy to be played with.

This is essentially a reasoning age. Superstition is nowhere; eloquence has lost its charm; sound logic overrides every thing because it leads to practical results. In every branch of research where the ends to be attained are such as promote the enjoyments and comforts of existence, we reason very sharply from what we know to what we don't know, advancing by successive parallels as in siege operations. The citadel is bound to be taken, especially if the spoil is tempting and valuable. Electrical science is just now carrying on a siege. It is in a state of transition from crude experiment and imperfect knowledge to results that would be astounding could they be clearly foreseen. The days are almost forgotten when land and ocean telegraphy was a novelty. The lighting of streets and buildings with the brilliant carbon is already making inroads on the sickly mal-odorous gas, the heating problem is being grappled with, and experiment is constantly developing new facts and principles in respect to the numberless uses to which electricity may be applied. It may be hazardous to predict that as a motor it will ever take the place of steam, but it would be no less hazardous to set bounds to the possibilities of what may yet be realized in this field of discovery.

#### NOVELTIES IN LOCOMOTIVE CONSTRUCTION.

If a revolution is not impending in the construction and capacity of passenger locomotives, it is not owing to any lack of ambitious and persevering effort in that direction. The Fontaine experiment does not so far seem to be either a success or a failure. Although it is not just now attracting any special attention, it may yet have a future far more brilliant than the Keeley abortion or the Prosser cylinder car. In the meantime, another experiment is in progress—the so-called hydrocarbon locomotive—the merits of which are set forth in somewhat florid style by a correspondent of the *Chicago Tribune*. The machine is in process of construction at the Grant Locomotive Works, Paterson, N. J., and if it turns out to be as big a thing on the track as it is on paper, the importance of the revolution that is likely to be effected by it can scarcely be exaggerated. Its peculiar feature is the generating and burning of hydrogen gas, producing an intense heat, which is distributed over a largely increased surface by means of small copper flues, the water being everywhere around and between them. The flame produced by the combustion is devoid of color and brightness, the great heat and the enormous evaporation are attended with a minimum cost of fuel, there is no forced draft, no noise from the exhaust, no smoke nor cinders, and the percentage of fuel economy as compared with coal-burning engines almost surpasses belief. The dead weight of fuel will be merely nominal, and no replenishment necessary during the longest runs. A number of minor advantages are also claimed, which

it is not worth while to enumerate at this preliminary stage. The weight of the locomotive will be 48 tons, cylinders 17 x 24 inches, driving wheels 61 inches. Its construction being already well advanced, the public will not have to wait long for the performance, the results of which will, it is confidently predicted, abolish coal-burning engines and all canal and sailing-vessel competition in transportation business.

#### QUALIFICATIONS OF MASTER MECHANICS.

We print the communication of a correspondent setting forth the importance of a preparatory course of elementary and technical instruction as a necessary qualification for railway master mechanics. Such a course of study would certainly be very desirable as a basis for the practical knowledge to be subsequently acquired, and were it made a prerequisite in every case, the results would no doubt be manifest in better and more satisfactory work. This, however, is not a new idea. The subject has often been discussed in mechanical journals. If master mechanics and master car-builders are, as a class, deficient in the science of engineering and a knowledge of technical formulas and methods of demonstration, it is not so much their fault as it is a fault of the system of which they form a part. The rapid extension of railroads and the enormous growth of traffic, together with the constant improvement in tools, machinery and appliances of every sort, have made the shops themselves the only practical seminaries for instruction, not in the higher elements of mathematics and knowledge of abstract principles, but in devising ways and means for meeting mechanical emergencies in the quickest and most practical way. Meanwhile, there has been a steady advance from the rude, primitive and unscientific, towards the present accepted standards of perfection. This inevitable progress must necessarily raise the standard of qualification. It cannot remain stationary, much less can it be lowered. Higher standards imply better pay. We are impressed with the notion that the road companies get value received for every dollar of salary now paid to their master mechanics and car-builders. But we are, nevertheless, in favor of the suggestion of our correspondent in regard to technical schools of instruction as a good thing in itself. Such schools would doubtless be largely instrumental in making the positions referred to more important and remunerative, and less subordinate than they now are.

#### WEIGHT OF MATERIAL IN FREIGHT CARS.

We copy the following from an article in the *Railway Review* on "The Utility of Weight in Cars":

"It is sometimes considered in construction that the quantity of material used increases the strength of the structure. In some instances it does; ordinarily it does not. Oftentimes an excess of material is a cause of weakness, as it would be in roof and bridge trusses, etc. Perhaps a greater latitude in this direction is permissible in car construction than in other classes of work. While the exercise of sound judgment in the use of material will insure strength and economy of construction in all kinds of work, yet many builders err on the heavy side because of their responsibility. Weakness in construction is always an evidence of ignorance. If an excess of heaviness or weight in the building of cars is allowable, it is because the car has a heavy load to carry, and the framework must be extra heavy and strong, to overcome the strain caused by the inertia of the load. Admitting that there is an excess of material used in the construction of cars, is it not necessary? The car-builder has to insure longitudinal stiffness, lateral strength; the load is to be supported with as little vibration as possible; and a combination of these conditions is requisite to save the loaded car from going to pieces when it suffers a derailment."

The economical adjustment of weight, strength

and carrying capacity in the construction of freight cars, is not an easy matter. The writer of the above extract, in what he says about excess of material, evidently refers to the floor-framing of cars, which consists of end and longitudinal sills, tie-timbers and bolsters, with the usual iron-rod trussing. So far as the weight of load and the draft and buffing strains are concerned, the floor-frame embodies the essential strength of the car, the other parts being relatively subordinate. For carrying the maximum load for which a car is rated, there need be no excess of material or weight in any part of the structure, if by excess is meant what is superfluous. The floor timbers must be stiff enough to carry the load without sagging, but any additional material increases the non-paying weight and taxes the motive power—very slightly it may be in the case of a single car, but in the economy of train expenses it is the aggregate of little things which tells. There is enough of dead weight to haul in the transportation of empty or partly loaded cars, without adding thereto a surplus of material beyond what the load requires. It is much easier to adapt the load to the car than the car to the load; and if this principle is not adhered to, car-builders can never know when a car of a given length has sufficient strength of material to carry the quantity of pig iron, or tin plate, or other heavy freight that may be put into it in a pressure of business. As regards collisions and derailments, a builder would hardly be warranted in constructing cars with an extra margin of strength sufficient to preserve them intact in such contingencies. Such accidents are exceptional, and the damage caused thereby by the wrecking of cars is doubtless less in the long run than the extra cost of building and hauling cars strong and heavy enough to stand the ordeal of accidents of this class. A few years ago, an extra heavy freight or passenger car was not considered creditable to the builder in an economical point of view. From present indications, there seems to be some danger of a reaction in the opposite direction.

The twelfth annual convention of the Master Car-Painters' Association was held at the Metropolitan Hotel, in New York, beginning on the 21st ult., and continuing three days. There was a good attendance, about 40 members being present and representing the prominent railroads of the country. A number of interesting papers were read, some of which we shall try to make room for in our future issues. The old officers of the Association were re-elected, as follows: President, D. D. Robertson, Michigan Central; Vice-President, J. H. Will, New York Central & Hudson River; Secretary and Treasurer, R. McKee, New York, Pennsylvania & Ohio.

The present activity in every branch of railway supply manufacture is really wonderful. There is an immense and constantly-increasing demand for machinery and tools for the equipment of new car shops in various parts of the country, and also to replace second-rate or worn-out appliances in old shops. So great is the accumulation of orders, and the reduction of certain kinds of machinery usually kept in stock, that contracts for early delivery are not easily made. Every day confirms this state of things as respects rolling-stock construction, repair and maintenance, and is a pretty sure indication that the roads have something to do, and that they are not incurring unnecessary outlays for business yet to be developed.

The inventor of a watch that winds itself up and gives a pint of milk a day has arrived in Washington to secure a patent.

"Do you go to Sabbath-school, my lad," kindly asked a city missionary of a depraved little Dubuque urchin. "Nary," answered the innocent child, "but I've got a fightin' cock that can walk over any bird in t'is town that wears galls."



## Cast-Iron Lathe Tools.

A correspondent of *The Effel Mechanical News* says he has received from Mr. G. W. Stratton, Master Mechanic of the Pennsylvania Railroad shops, at Altoona, two cast-iron lathe tools used at those shops, and made of the usual mixture put in the drilled tread of car wheels. The tools of this description are of the various forms used for planing and turning, and are chilled about half an inch at the point, and ground to an edge on an emery wheel. They give three times the service of cutters made of the best tool steel, under the same conditions, without grinding, and are found to be very useful upon cast iron, brass work, and even upon steel that is very hard. They are also used in the planing of locomotive cylinders, slide-valves and eccentrics, the planers being run at the usual speed.

This is not a new discovery, but none the less valuable on that account. Mr. W. H. Paige, the former superintendent of the Wason Car Co., at Springfield, Mass., used chilled cast-iron cutters for turning axles two years ago, and found them to be far more serviceable than those made of steel, and a great deal cheaper. That they are not more generally used is due in part to ignorance of their merits, and in part to prejudice, and not to any inherent defect in the tools themselves on account of the material of which they are made.

*The Coach Painter* for Sept. 15, in addition to its usual attractive variety of matter, is accompanied with a 2-page supplement of rare artistic merit—a side elevation of a Pennsylvania R.R. locomotive and passenger car, colored, tinted, bronzed, varnished and lettered with a beauty and delicacy that fairly counterfeits the best work of the shops. It is a superb piece of color printing, and worthy of a glass and frame.

*The Industrial News*, an illustrated monthly journal published by the Inventors' Institute, Cooper Union, New York, contains a variety of well selected matter of special interest to readers who desire to keep pace with the progress of invention and the mechanic arts. It is well printed, and contains a monthly digest of patent decisions.

*The Painters' Magazine* contains a mass of well selected and digested information in reference to the technicalities of house, car and locomotive painting, with illustrations of decorative designs, lettering, etc., and prices current of paints and varnishes. It should be in the hands of every car painter. Published monthly, 72 William street, New York. N. C. White, Editor. Price, \$1.50 per year.

*Fifteenth Annual Report of the Master Car-Builders' Association.*—The regular report of the proceedings of the convention held in New York in June last has just been published in the usual form, but containing about 100 pages more than last year's report. The discussions are very fully reported, and, so far as appears from a brief examination, are a faithful record of the views of members upon the subjects presented for consideration. The reports of committees and the substance of the discussions have already been published in the CAR-BUILDER and other railway journals, but the full report is none the less worthy of careful examination by railway men and others who would form an intelligent judgment of the usefulness of the Association in the matter of improved construction and management of the various classes of railway cars.

Traveler—How do you brokers manage to undersell the railroad companies?

Scalper—Vell, you see, we don't got so much expenses. Dose railroad fellers haf to keep up the rolling stock an' pay ze hands. We don't. It's all clear profit with us!—*Ec.*

SPEAR'S anti clinker coal-burning car stoves are already too well known to railway men and the traveling public to need special commendation. But as the winter is close at hand we take pleasure in calling attention to the Spear stove designated as pattern A, as combining in a most effective way the essentials of heating and ventilation. The cold air from the outside is introduced at the bottom, and is heated by passing up on one side and down on the other to an opening in the base, where it is discharged into the car and distributed so as to produce a uniformity of temperature, while the vitiated air is forced out at the top. The heated surface of the stove is at the same time protected by a sheet-iron drum casing, which prevents the air in the car from being cooked and rendered unfit for breathing, while at the same time those sitting near the stove are not incommoded by an excess of heat. The stoves are securely fastened in their places, and the doors prevented from flying open in case of accident, by wrought-iron latches held down by a cam.

PARKER'S CEMENT PAINT, manufactured by Cary, Ogden & Parker, Chicago, Ill., and adapted to railroad buildings, cars and car roofs, is one of the cheapest, most durable and effective preservatives for every kind of surface exposed to the weather. It is proof against moisture, is unaffected by heat or cold, covers better, works smoother, and is said to be equal to three coats of minerals mixed in the old way. It is composed of pure linseed oil, with no rosin or other injurious ingredients, is put up in eight different shades ready for the brush, and is guaranteed for five years. The firm is among the largest of the manufacturers of this class of goods at the West, and has unequalled facilities in its line, which includes coach colors, truck and roof shades, white lead, etc. It is supplying some of the leading car ways and car manufacturers in the country, and its business is daily increasing. Specimens of cement paint attached to circulars, which will be sent on application.

THE EMPIRE PORTABLE FORGE CO., Cohoes, N. Y., manufacture forges for blacksmith work, with blowers that can be worked by hand or by power, producing a steady and uniform blast adjusted to suit any requirement. The "Western Hand-Blower, No. 1," with its adjustable tuyere, enables the operator to increase the quantity of blast for heavy work without increasing its strength, which can not be done with the bellows or other force blower. The frame is of angle-iron and is perfectly rigid; the fan does not slip or stretch, rot or burn; the wind blast is equal to that of Smith's large bellows, is worked by a swiveled handle; the bearings are Babbitted, and the gear wheels simple, accessible and easily replaced or repaired. It is, in fact, one of the most economical and responsible appliances ever invented for blacksmith work.

THE EUREKA POST-HOLE DIGGER, manufactured by Campbell & Lill, 228 Lake street, Chicago, is claimed to be the most effective of this class of tools. There is no clogging, knee-work or back-ache in its working, and it is equally adapted to stony, sandy or clay soils, doing the work much quicker than it can be done with plungers, augers or boring machines. It was awarded the grand medal and diploma at the Centennial Exposition, and has never failed to receive prizes at the State and county fairs. Some of the leading railroads in the country are using it, especially at the West.

AN unsophisticated person, with an inquiring habit of mind, was investigating the mysteries of a buzz-saw in a factory in Norwich, Conn., the other day, when he laid two of his fingers upon it to see if it was going. *It tears.*

A SLEEPER is one who sleeps; a sleeper is also a place where a sleeper can sleep; and is, too, a thing over which runs the sleeper in which the sleeper sleeps. So that the sleeper in the sleeper sleeps while the sleeper runs over the sleeper as well as sometimes when it leaps off the track.

A COUNTRY paper says: "Lives there a man with soul so dead, who never to himself has said, 'I'll pay before I go to bed, the debt I owe the printer? Yes, there are some I know full well, who never such a tale could tell, but they I fear will go to—well, the place where there's no winter."

AN Atlanta negro was very busy eating a watermelon at the Whitehall crossing as the State road train came in, when the locomotive with its glaring headlight struck him and landed him some rods out in the darkness. As he picked himself up he exclaimed, "Who swung dat lamp? Who frowed dat brick?" The locomotive was but slightly injured.

## Our Directory.

We note the following changes since our last issue. Readers are requested to give us prompt notice of changes when they occur:

*Ashtabula & Pittsburg.*—Mr. J. M. Kimball has been appointed Superintendent, in place of D. B. McCoy, resigned.

*Atchison, Topeka & Santa Fe.*—Mr. P. Leeds has been appointed Superintendent of Southern Division.

*Chicago & Alton.*—Mr. Wm. McPhail has been appointed Master Mechanic of Kansas City Division, in place of Jas. T. Todd, resigned.

*Cleveland, Columbus, Cincinnati & Indianapolis.*—Mr. W. C. Quigley has been appointed Master Mechanic of Indianapolis Division, in place of A. R. McAlpine, resigned.

*Columbus, Hocking Valley & Toledo.*—This is the consolidated name for the Columbus & Hocking Valley and Columbus & Toledo roads.

*Des Moines & Northwestern.*—Mr. H. B. Steel has been appointed General Superintendent.

*Evansville & Terre Haute.*—Mr. O. S. Lyford, General Superintendent of the Chicago & Eastern Illinois, has been appointed General Superintendent of this road also.

*Kentucky Central.*—Mr. J. H. Setchel, formerly of the Little Miami road, has been appointed Master Mechanic.

*Louisville, New Albany & Chicago.*—Mr. Josiah Betts has been appointed Master Mechanic, vice Mr. Geo. H. Ruhlandt, resigned.

*Louisville, New Albany & St. Louis.*—Mr. J. Martin Shepherd, resigned.

*Maine Central.*—Mr. J. W. Philbrick has resigned his position as Master Mechanic. Ira K. Russell has been appointed Foreman of Machinery, and Charles H. Kenyon Foreman of Car Repair Shops.

*New York, Chicago & St. Louis.*—Mr. Lewis Williams has been appointed General Manager, with office at Cleveland.

*Philadelphia, Wilmington & Baltimore.*—Mr. C. K. Lodge has been appointed Superintendent of the Central Division, which consists of the Westchester & Philadelphia and Philadelphia & Baltimore Central.

*Pittsburg, Cincinnati & St. Louis.*—Mr. E. B. Taylor is appointed Superintendent of P. C. & St. L. Division, in place of J. H. Barrett, resigned.

*St. Paul & Duluth.*—Mr. J. G. Callahan has been appointed Purchasing Agent.

*Texas & Pacific.*—Mr. Henry Bearup has been appointed Master Mechanic in charge of the shops at Marshall, Tex. He has been for 15 years on the Lake Shore & Michigan Southern.

*Toledo, Delphos & Burlington.*—Mr. F. A. Phillips, formerly of the Atlantic & Great Western, has been appointed General Manager.

*Troy & Boston.*—Mr. E. Crandell, late General Freight Agent, has been appointed Superintendent, in place of Eben E. Aldrich, deceased.

*Union Pacific.*—Mr. O. H. Dortance, formerly of Texas & Pacific, is appointed Superintendent of the Western Division of the Kansas Division, in place of John T. Odell, who has gone to the Mexican Central.

WANTED.—By a competent man of 30 years' experience, a situation as Mechanical Draughtsman or Foreman of a Machine Shop. Address NATIONAL CAR-BUILDER, 5 Day street, New York.

WANTED.—A competent MASTER CAR-BUILDER, who can successfully manage a car works, and take an interest in same to amount of \$10,000 or \$15,000. Address office of NATIONAL CAR-BUILDER, or S. R. Shaw & Co., St. Louis, Mo. A fine opportunity for a good man.

## CONTINUOUS DRAW-BAR PATENTS.

The following circular has been issued by the Secretary of the Western Railroad Association: CHICAGO, Sept. 9, 1880.

To the Members of the Association:—GENTLEMEN: Claims have been pending for several years that the Continuous Draw-Bar sold by the Continuous Draw-Bar Company under the Middleton and the Griffith and Taiter patents is an infringement of patent 71,280, granted 3d December, 1867; reissue No. 8,000, granted 19th February, 1878, to Edward L. Cunn.

This Association has continuously advised against entering this claim, but to quiet all questions, and at our suggestion, the Continuous Draw-Bar Company has recently purchased the Cunn patent, its owners inserting in the assignment a full and absolute release to all the members of the Eastern and Western Railroad Associations from any and all liability for, or on account of, any infringement heretofore of said patent.

Yours truly,  
J. H. RAYMOND, Secretary, etc.



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PENNSYLVANIA CO., Wm. Mullins, General Purchasing Agent, Pittsburgh, Pa.  
BALTIMORE & OHIO RAILROAD CO., N. S. Hill, Purchasing Agent, Baltimore Md.  
CHICAGO & ALTON RAILROAD CO., A. V. Hartwell, Purchasing Agent, Chicago, Ill.  
CHICAGO & NORTHWESTERN RAILROAD CO., R. W. Hanner, Purchasing Agent, Chicago, Ill.  
LEHIGH VALLEY RAILROAD CO., L. Chamberlin, Purchasing Agent, Philadelphia, Pa.  
NORTHERN RAILROAD OF CANADA, F. W. Cumberland, Superintendent, Toronto, Ont.  
NAUGATUCK RAILROAD CO., G. W. Beach, Superintendent, Waterbury, Conn.  
PHILADELPHIA, WILMINGTON & BALTIMORE RAILROAD CO., S. A. Hodgman, Superintendent of Motive Power, Wilmington, Del.  
NEW YORK, NEW HAVEN & HARTFORD RAILROAD CO., R. N. Dowd, Commissary, New Haven, Conn.

UNION PACIFIC RAILROAD CO., A. D. Clark, Purchasing Agent, Omaha, Neb.  
KANSAS  
CHICAGO, BURLINGTON & QUINCY RAILROAD CO., Wm. Irving, Purchasing Agent, Chicago, Ill.  
LOUISVILLE, CINCINNATI & LEXINGTON RAILROAD CO., Wm. Mahl, Purchasing Agent, Louisville, Ky.  
GRAND TRUNK RAILWAY N. Wall, Port Huron, Mich.  
LITTLE ROCK & FORT SMITH RAILROAD CO., T. Hartman, Purchasing Agent, Little Rock, Ark.  
GILBERT & BUSH CO., Troy, N. Y.  
WASON MANUFACTURING CO., Brightwood, Mass.  
HILLMEYER & SMALL MANUFACTURING CO., York, Pa.  
JACKSON & SHARP CO., Wilmington, Del.  
BARNEY & SMITH MANUFACTURING CO., Dayton, O.

The advantages derived from the use of such Special Colors are many, a few of which are found below:  
**ABSOLUTE UNIFORMITY OF SHADE. DURABILITY.** as we use perfectly pure materials. **SAVING OF MONEY,** because of small quantity required. **SAVING OF TIME,** in the putting on of the same. **SAVING OF LABOR AND MATERIAL,** as no extra amount of Varnish will be required to hide a sanded surface. **LARGER DEGREE OF CERTAINTY** that there will be an absence of cracked work, as our mixtures are all uniform, being done by weight only. We make any desired shade, it only being necessary that purchasers furnish us with sample of color desired, stating the time they would like to have the paint dry in. We shall be glad to furnish samples and give prices to any who may wish to avail themselves of the above advantages.

Very respectfully,

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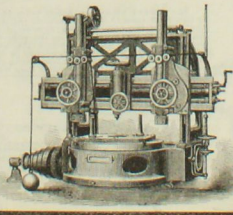
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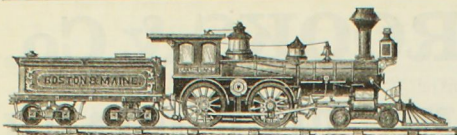
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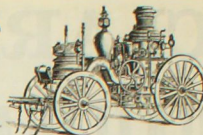
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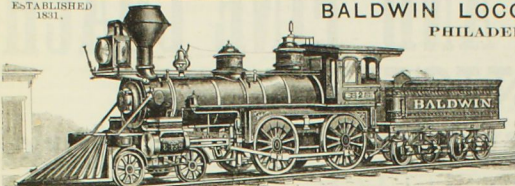
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WM. G. MEANS, Treas., Boston, Mass.

ABETAS BLOOD, Agent, Manchester, N. H.



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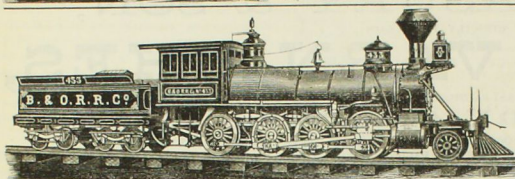
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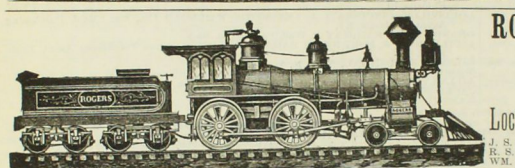
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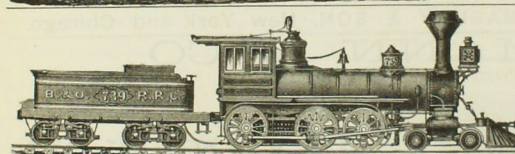
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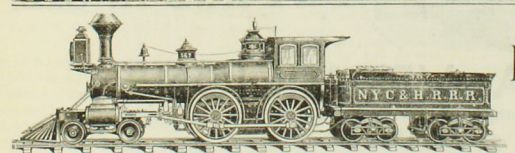
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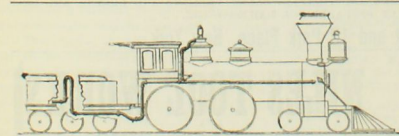
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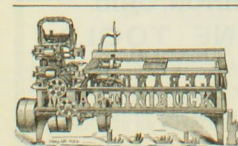
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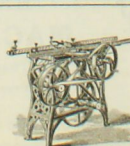
271 Franklin Street, Boston, Mass.



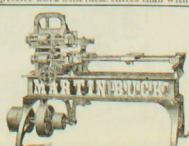
The Ashton Blow-back Safety-valve is constructed so as to conduct the escape steam which is blown off back to the tender, or to the smoke-box and up the chimney. By this arrangement the heat of the escape steam, instead of being wasted as it is when an ordinary safety valve blows off, is communicated to the cold water in the tender. This not only results in an important economy, but it renders the escaping steam harmless, and the increase of temperature of the water has a tendency to deposit some of its impurities before it is pumped into the boiler. It thus stops the waste of water, and all engines blow better and faster, and do more effective work with these valves than with those in ordinary use.



Double Car Tenoner.



Hand Mortiser.



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Single, Double and Triple Tenoners and Gaining done on the same machine; especially adapted to car work. Single Tenoners, all iron, with carriage mounted on trucks; Hand Mortiser and Borer combined for fixed and rolling clats; Adjustable Groover Heads, and a full line of Wood working Machinery.

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NEW DESCRIPTIVE CIRCULAR ON APPLICATION.



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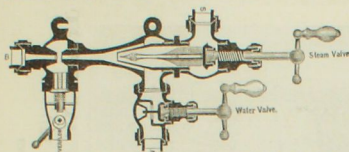
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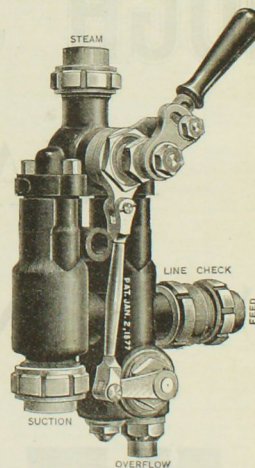
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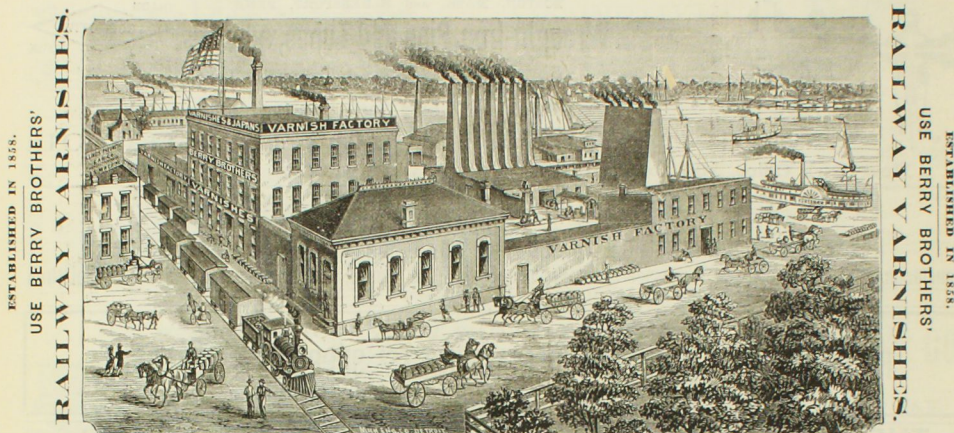
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<i>Railroad</i>	<i>Master-Mechanic</i>	<i>Master Car-Builder</i>	<i>Residence</i>
Chicago, Rock Island & Pacific	J. B. Twombly	M. K. Verbruck	Chicago, Ill.
Illinois Division	R. Biester	Chas. M. Leonard	Davenport, Ia.
Iron Division	Jas. Morrill	Henry Knauer	Keokuk, Iowa
Keokuk & Des Moines Div.	S. W. Wakefield	Chas. E. Burt	Stuart, Ia.
Southwestern Division	W. J. Crockett	Russell Booth	Muskegon, Mich.
St. Louis Division	Russell Booth	Jas. T. Kerney	Aurora, Ill.
Chicago & West Michigan	J. M. Bryan	John Ballie	Milwaukee, W.
Chicago & Eastern Illinois	J. M. Lowry	Wm. E. Kittredge	Milwaukee, W.
Chicago & Iowa		E. A. Eddy	Racine, Wis.
Chicago, Milwaukee & St. Paul			
La Crosse & River, N. Div.			
Northern Division	J. O. Pattie		
Lawrence & Minn. Division	J. O. W. Smith		
Rock Island & Pacific			

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[OCTOBER, 1881.]

OCTOBER, 1881.]

THE NATIONAL CAR-BUILDER.

XV

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
Spartanburg, Union & Columbia	Wm. Platt	W. B. Brown	Spartanburg, S. C.
State Line & Sullivan	J. O. Blight	M. S. Webb	Towanda, Pa.
Stockton & Copperopolis	G. H. Cousen	H. C. Tucker	Stockton, Cal.
St. Croix & Penobscot	Jas. M. Owens	F. A. Chase	Milltown, Me.
St. Johns	Geo. E. Howe	E. Sheppy	St. Augustine, Fla.
St. Johnsbury & Lake Champlain	Calvin Hane	Calvin Hane	St. Johnsbury, Vt.
St. Joseph & Des Moines	F. A. Chase	E. Sheppy	St. Joseph, Mo.
St. Joseph & Western	L. Finlay	L. Finlay	So. St. Joseph, Mo.
St. Lawrence & Ottawa	*O. A. Haynes	Oscar Doolittle	St. Louis, Mo.
St. Louis, Iron Mount & So.	W. H. Harris	H. M. Aldrich	Little Rock, Ark.
Missouri Division	Thomas Warren	Wm. Grosvener	St. Louis, Mo.
St. Louis, Alton & Terre Haute	M. Kearney	M. Kearney	St. Louis, Mo.
St. Louis, Salem & Little Rock	Wm. Foley	Wm. Foley	Kirkuk, Iowa
St. Louis, Keokuk & Northwest	Wm. McFarland	John Hill	St. Louis, Mo.
St. Louis Bridge Co. & Tunnel R.R.	H. A. Ackerly	John Hill	St. Paul, Minn.
St. Paul & Duluth	Wm. McFarland	John Hill	St. Paul, Minn.
St. Paul, Minneapolis & Manitoba	Wm. McFarland	John Hill	St. Paul, Minn.
St. Paul & Sioux City	Wm. McFarland	John Hill	St. Paul, Minn.
Sussex & Haverhill	Wm. McFarland	John Hill	St. Paul, Minn.
Syracuse, Binghamton & N. Y.	Wm. McFarland	John Hill	St. Paul, Minn.
Syracuse, Chenango & New York	Wm. McFarland	John Hill	St. Paul, Minn.

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
Eastern Division	A. M. Collett	A. M. Collett	Omaha, Neb.
Eastern Division	H. P. Makely	H. P. Makely	Grand Island, Neb.
Mountain & Laramie Div.	T. A. Davis	T. A. Davis	Cheyenne, Wg. T.
Western Division	R. V. Brinkley	R. V. Brinkley	Evanson, Wg. T.
Colorado Division	James S. Scott	E. G. Thomas	Golden, Col.
Denver, S. Park & Pacific Div.	J. H. Kirk	J. H. Kirk	Denver, Col.
Kansas Division	*John MacKenzie	J. B. Roberts	Kansas City, Mo.
Kansas Division	John B. Daily	John B. Daily	Ellis, Kan.
Kaw Valley Division	Jas. McKenzie	Sam. S. Tucker	Armstrong, Kan.
Utah Central	W. B. Armstrong	Sam. S. Tucker	Salt Lake City, U.
Utah Western	Robert Anderson	Robert Anderson	Salt Lake City, U.
Utah & Black River	John Bailey	David James	Utica, N. Y.
Utica, Black & Elmira	Geo. W. Cleveland	F. W. Macargill	Breeseport, N. Y.

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
Valley	B. C. Bosworth	Chas. Blanchard	Cleveland, O.
Vicksburg & Meridian	Jas. B. Browne	Jas. B. Browne	Vicksburg, Miss.
Vicksburg, Shreveport & Pacific	W. Bell Smith	W. Bell Smith	Monroe, La.
Virginia & Truckee	J. N. Fordling	J. N. Fordling	Carson, Nev.
Virginia Midland	J. E. Wadley	J. T. Nallo	Fort Alexandria, Va.

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
Wabash, St. Louis & Pacific	Chauncy B. Morris	Chauncy B. Morris	Fort Wayne, Ind.
Wabash, St. Louis & Pacific	Jacob Johann	B. B. Rose	Springfield, Ill.
Wabash, St. Louis & Pacific	W. O. Hewitt	B. B. Rose	Peoria, Ill.
Wabash, St. Louis & Pacific	U. H. Kohler	U. H. Kohler	Toledo, Ohio
Wabash, St. Louis & Pacific	J. S. Hazen	J. S. Hazen	Stansbury, Mo.
Walkill Valley	W. H. Sealy	W. H. Sealy	Moberly, Mo.
Washington & Ohio	John Harrison	John Harrison	Alexandria, Va.
Western & Atlantic	James Taylor	Wm. H. Fay	St. Catharines, C.W.
Western Maryland	John H. Flynn	W. G. Grambling	Atlanta, Ga.
Western North Carolina	Geo. W. Gates	Robert King	Union Bridge, Md.
Western of Alabama	Isaac W. Clark	Isaac W. Clark	Salisbury, S. C.
Western R. R. N. C.	John Taylor	E. A. Eddy	Montgomery, Ala.
West Feliciana	A. A. Tilton	J. A. Tilton	Fayetteville, N. C.
West Jersey	W. McAllister	C. C. Williams	Racine, Wis.
White Water	Al. W. Wingert	Al. W. Wingert	Bayon Sara, La.
Wilmington, Columbia & Augusta	John Hisset	W. H. Day	Camden, N. J.
Wilmington & Weldon	John Hisset	C. R. Clove	Harrison, O.
Wisconsin Central	J. H. Henney	J. H. Henney	Florence, S. C.
Wisconsin Valley	A. B. Snyder	A. B. Snyder	Wilmington, N. C.
Worcester & Nashua	John G. Brady	John G. Brady	Stevens Pt., Wis.

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
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T. H. & Indianapolis	Wm. C. Peddie	E. D. Carter	Terre Haute, Ind.
Indianapolis Div.	Chas. Butler	Chas. Butler	Indianapolis, Ind.
Leavenworth Division	A. W. Quackenbush	J. M. Mather	Leavenworth, Kan.
Texas & New Orleans	D. C. Smith	H. H. Sessions	Houston, Texas.
Texas & Pacific	H. Bearup	H. H. Sessions	Marshall, Texas.
Trona Division	Pere Benay	D. H. Stratton	Dallas, Tex.
Toledo, Delphos & Burlington	David Preston	David Preston	Blossburg, Pa.
Toronto, Grey & Bruce	F. M. Mast	F. M. Mast	Delphos, O.
Toronto & Nipissing	J. Haggas	J. Haggas	Toronto, Can.
Troy & Roston	Z. R. Davis	R. V. Coon	Troy, N. Y.

Railroad.	Master Mechanic.	Master Car Builder.	Residence.
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Union Pacific	Chas. H. Congdon	Geo. E. Stevens	Omaha, Neb.

IN THE

# PATENT FIGHT

BETWEEN

## D. A. HOPKINS, of 113 Liberty St., N. Y.

PATENTEE AND MANUFACTURER OF

# SELF-FITTING JOURNAL BEARINGS

AND

## T. V. LE ROY,

A DECISION HAS JUST BEEN RENDERED

# IN FAVOR OF HOPKINS.



REFERENCES.—\* General Manager. † General Superintendent. ‡ Assistant General Superintendent. § Assistant Superintendent. \*\* Superintendent of Transportation. §§ Assistant General Manager.

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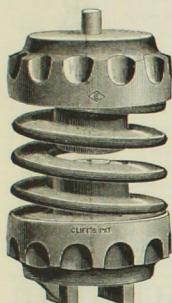


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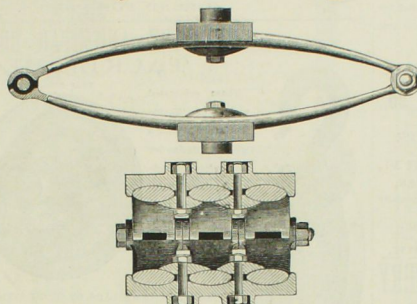




**CLIFF BUFFER.**  
5½ by 8. 2¼-in. hole  
Capacity, 16,500 lbs.

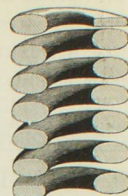


CLIFF'S GRADUATED EQUALIZER.  
7½ in. diam., 11¾ in. high.  
Capacity graduated from 7,000  
10,000 lbs.

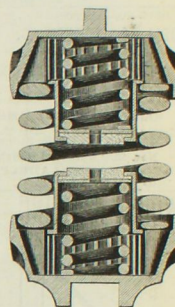


Transverse Sectional View.

**ACME TRIPLET FREIGHT ELLIPTIC.**  
CLIFF'S PATENT, MARCH 20, 1881.  
22 in. long. 6¼ in. bearing to bearing.  
Capacity, 28,500 lbs.



*Sectional.*  
**CLIFF BUFFER.**  
5¼ x 8. 2¼-in. hole  
Capacity, 18,500 lbs



Sectional.  
CLIFF'S GRADUATED EQUALIZER.  
7½ in. diam., 11¼ in. high.  
Capacity graduated from 7,000 to  
10,000 lbs.

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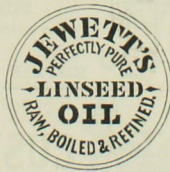
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Our BOILED OIL will be, as heretofore,  
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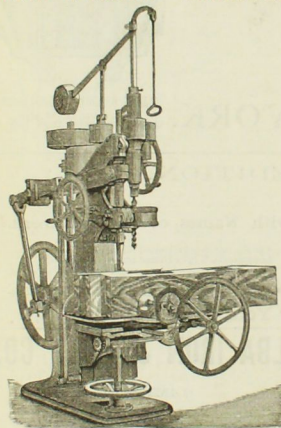
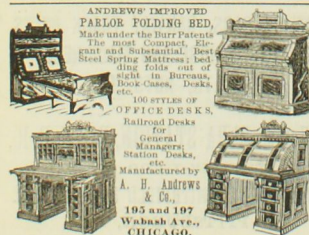
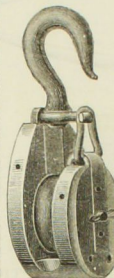
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FIG. 12

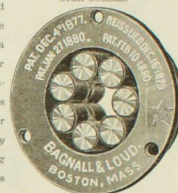
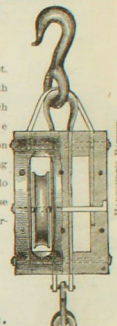
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The most Compact, Elegant  
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**A. E. ANDREWS  
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**CHICAGO.****NEW ENGLAND GLASS WORKS.****W. L. LIBBEY & SON,**

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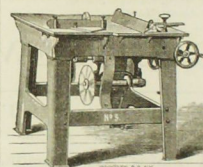
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**RUBY, GREEN AND BLUE,**FOR  
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BLOCK.**METALINE AND STAR ROLLER BUSHED  
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on account of their  
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over all other kindsnow in the market.  
These, together with  
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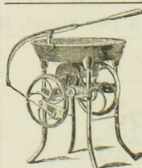
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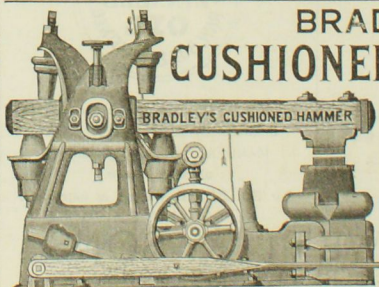
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AND LEVER HANDLE. CHEAPEST MADE

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**WITHOUT AN EQUAL.**It approaches nearer the action of  
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the world.**BRADLEY & COMPANY,**  
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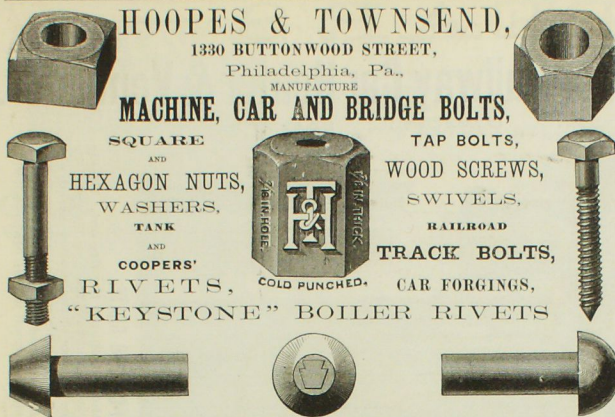
[Established 1832.]



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**EATON'S**  
**Patent Car Stove**  
IS THE  
Safest, most Economical and Comfort-  
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AS ALL ROADS USING THEM  
WILL TESTIFY.



As may be seen in the sectional view, the draft passes through the register in the front of the drum, and passing down through the double back and bottom, reaches the fire from the front; the air being thus warmed, does not cut out the wood, like a direct draft of cold air, nor carry the greater part of the heat out through the pipe instead of radiating it through the sides.

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has many advantages over all other stoves. It burns less wood and gives more heat than any stove yet made. The cold air to feed the fire being taken into the stove above, the air becomes heated in passing to the fire, and causes a slower combustion, while the extra amount of radiating surface causes more heat to be thrown off. It has the advantages of a cast-iron and a sheet-iron stove combined. It is securely fastened to the floor. The door and damper are locked, and in case of collision cannot be displaced.

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**DIRECTIONS.**—For cars or engines, pack the box so that the Compound will come in contact with the bearing and journal, using waste saturated with oil; also moisten the Compound with oil.  
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When a journal is hot, don't cool it with water, but apply the Compound; and no matter how hot it is, it will cool it while in motion.

When you apply new bearings, fill them with the Compound before putting them on the axle, and pack the sides of the box next to the bearing with the Compound, and your boxes will run cool.

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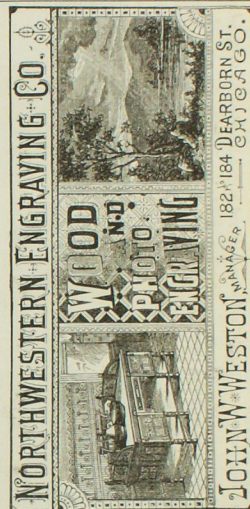
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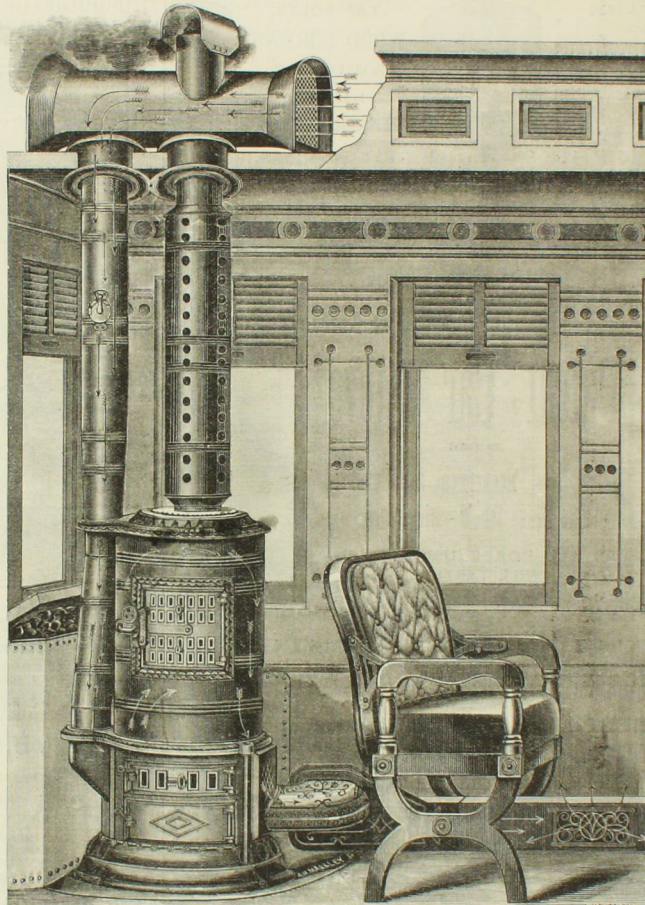
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## Improved Anti-Clinker Railway Car Heater & Ventilator.

HEALTH! COMFORT! SAFETY!

### WE CLAIM FOR OUR HEATERS THE FOLLOWING ADVANTAGES OVER ANY OTHER IN USE FOR RAILWAY CARS.

- 1.—An equal quantity of hot air is distributed throughout the car.
- 2.—Persons sitting near the stove are not hotter than those at a distance, and are not obliged to open the windows, to the annoyance of others.
- 3.—All the impure air is driven out at the top of the car.
- 4.—The air in the car never comes in contact with the heated surface of the stove, as all the air that is heated is brought fresh from the outside—thus heating and ventilating the car at the same time.
- 5.—There is no danger of accidents from passengers' clothing taking fire by coming in contact with the stove.
- 6.—In numerous cases where cars containing this stove have been overturned, it has never been known to set fire to the car, or even to be moved out of its place.



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We invite special attention to the above cut, which illustrates our improved Anti-Clinker Car Heater and Ventilator. Many devices have been tried for heating and ventilating railway cars, and most of them have proven failures, but by our improved plan, cars can be thoroughly heated and ventilated. The fresh air is taken in at the top of the car through the ventilator, passing down a pipe to the base of stove, around the heated cylinder, and through a 4 x 6 tin pipe along the side of car, escaping through registers between the seats, thus warming the feet of passengers, thoroughly heating the car, and forcing the foul air out through the top openings. In making the attachment from heater to tin pipe we use a cast-iron elbow, which makes a complete connection between the heater and hot-air pipes. Persons who travel in railway cars know how uncomfortably hot the seats are near the stove, and how often they are obliged to raise the windows, to the annoyance of passengers at a distance from the stove, who are suffering from the cold; and also how

ILLY VENTILATED most cars are, on account of the air in the car coming in contact with the heated plates of the stove.

WOULD BE PLEASED TO HAVE YOU CONSIDER OUR IMPROVEMENT AND THE UTILITY OF USING IT IN YOUR CARS.

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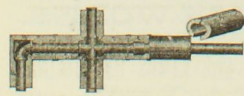
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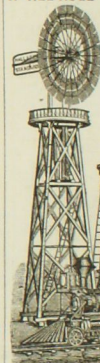
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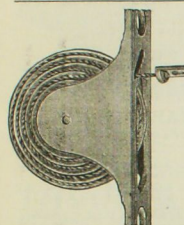


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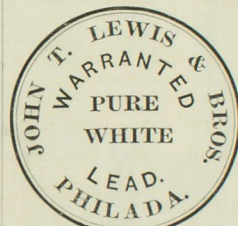
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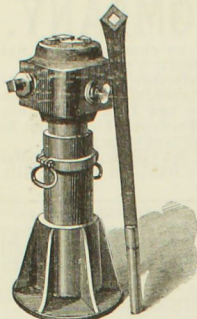
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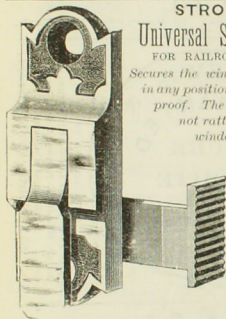
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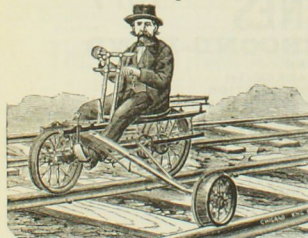


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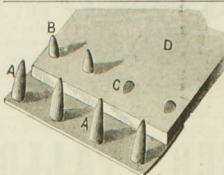
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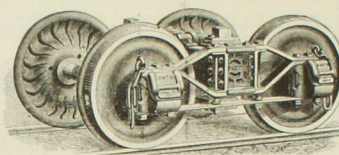
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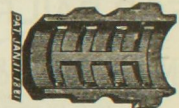


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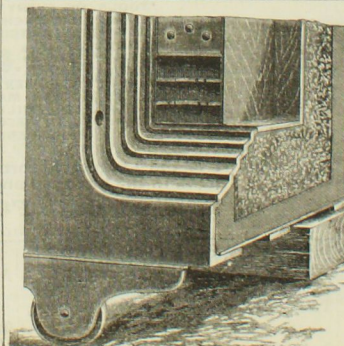
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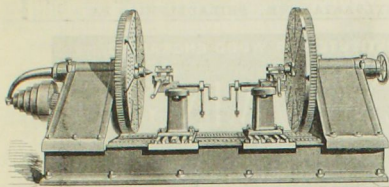
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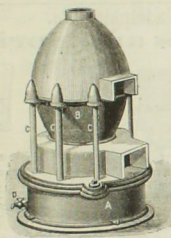
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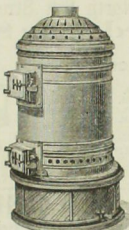
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No. 1. Shows a cross-section of the Winslow's Safety Car Stove, with the fire door open, showing the interior of the stove, and the fire door closed, showing the exterior of the stove.



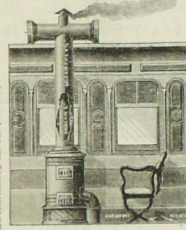
NO. 1.

No. 2. Shows a cross-section of the Winslow's Safety Car Stove, with the fire door open, showing the interior of the stove, and the fire door closed, showing the exterior of the stove.



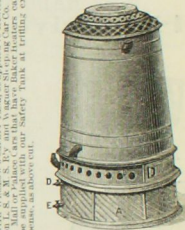
NO. 2.

No. 3. Shows a cross-section of the Winslow's Safety Car Stove, with the fire door open, showing the interior of the stove, and the fire door closed, showing the exterior of the stove.



NO. 3.

No. 4. Shows a cross-section of the Winslow's Safety Car Stove, with the fire door open, showing the interior of the stove, and the fire door closed, showing the exterior of the stove.



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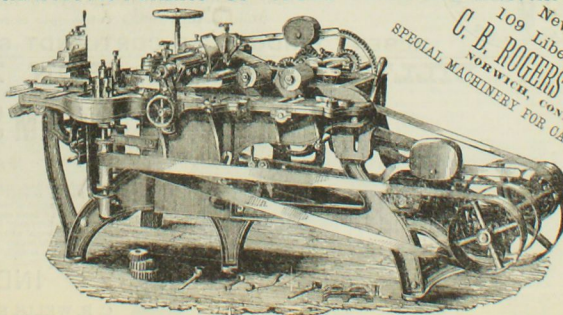
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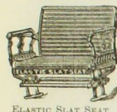
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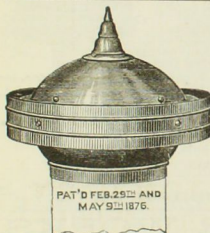


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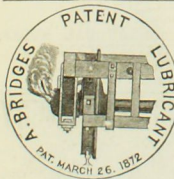
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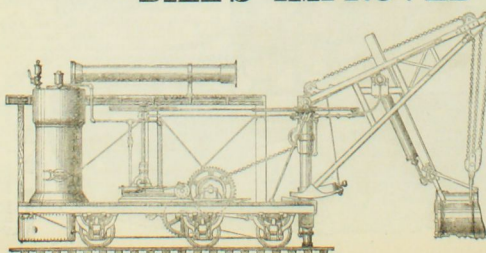
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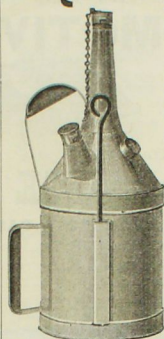
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For Cooling Railroad Car and Steamboat Journals,  
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Mixing with Other Oils.



The attention of those who are running heavy journals is respectfully invited to the above Liquid Cooler. It has been successfully used for upward of ten years, and is constantly growing in favor, as its merits become known, and we are confident that practical men cannot fail of being convinced that our preparation deserves their candid attention. What we claim for it is:

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**Only Preparation that will Cool a Hot Journal**

while it is in motion, as attested by certificates below; that one thorough application on a hot journal will do more execution in cooling than the constant application of water for half an hour, besides doing it evenly and without loss of time.

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Yours truly,  
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I can recommend Noyes' Liquid Cooler as an excellent article to carry on trains for use in case of Hot Journals, which it cools, without injury to the journals, more effectually than anything I know of.  
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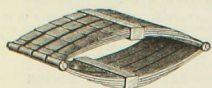


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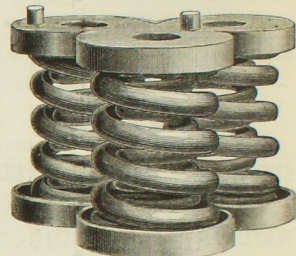
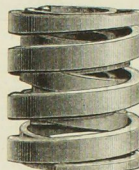
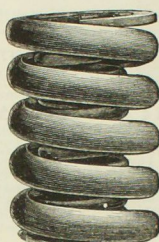
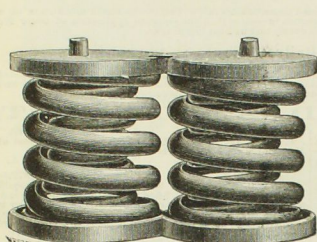
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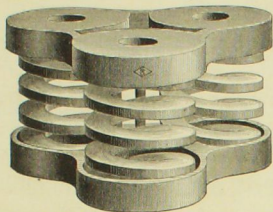
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3

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Height ..... 6 1/2  
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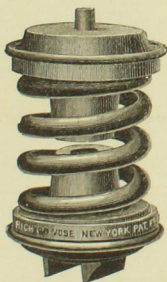
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NEW YORK.

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Car Spring Company,

RICHARD VOSE, President.

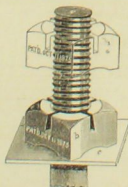
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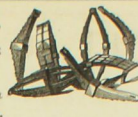
J. W. LARABEE,  
TREASURER.

a. Atwood Nut on bolt without bearing on base—slots open.  
b. Atwood Nut turned to bearing, c. partially closing the  
lots and grasping the bolt.

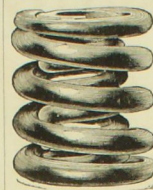
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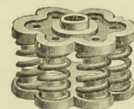
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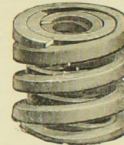
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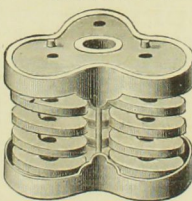
F. H. ANDREWS, President and Treasurer.

B. A. CLOONEY, Sec. and Gen'l Superintendent.

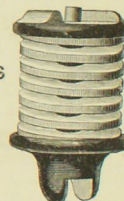


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SPIRAL SPRINGS  
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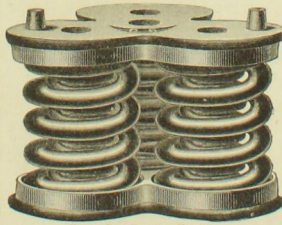


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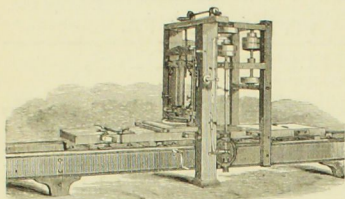
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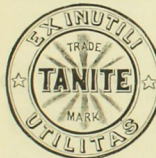
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#### NONPARIEL SPECIAL TOOL STEEL.

This is a specially prepared steel made for cutting hard metal, and possesses the following advantages over any other special steel in the market. I.—It does not require special skill in working, and can be readily forged to any shape. II.—It does not require tempering, simple hardening in water being sufficient. III.—It will make either a roughing or finishing tool. IV.—It will cut with the same facility chilled rolls, hard casting, steel and wrought iron. V.—Under hard work, at a high rate of speed, a tool made of this steel will keep a fine edge longer than any steel extant. Every Bar Warranted. Manufactured by

THE PHILADELPHIA STEEL FORGE, No. 315 WILLING'S ALLEY, PHILADELPHIA, PA.

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